Gold Bond

HANDBOOK

CATALOG OF GOLD BOND

WALL AND CEILING

BUILDING MATERIALS

· 1939 ·

THE Gold Bond HANDBOOK

ON RELATED PRODUCTS FOR WALLS AND CEILINGS

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NATIONAL GYPSUM COMPANY, BUFFALO, N. Y.

BRANCH OFFICES: NEW YORK BOSTON CHICAGO DALLAS PHILADELPHIA ATLANTA MINNEAPOLIS ST. LOUIS

PLANTS: PORTSMOUTH, N. H. NEW YORK, N. Y. CLARENCE CENTER, N. Y. NATIONAL CITY, MICH. AKRON, N. Y. YORK, PA. LUCKEY, OHIO NILES, OHIO ROTAN, TEX. SAVANNAH, GA. MOBILE, ALA. FORT DODGE, IOWA MEDICINE LODGE, KAN. ORANDA, VA.





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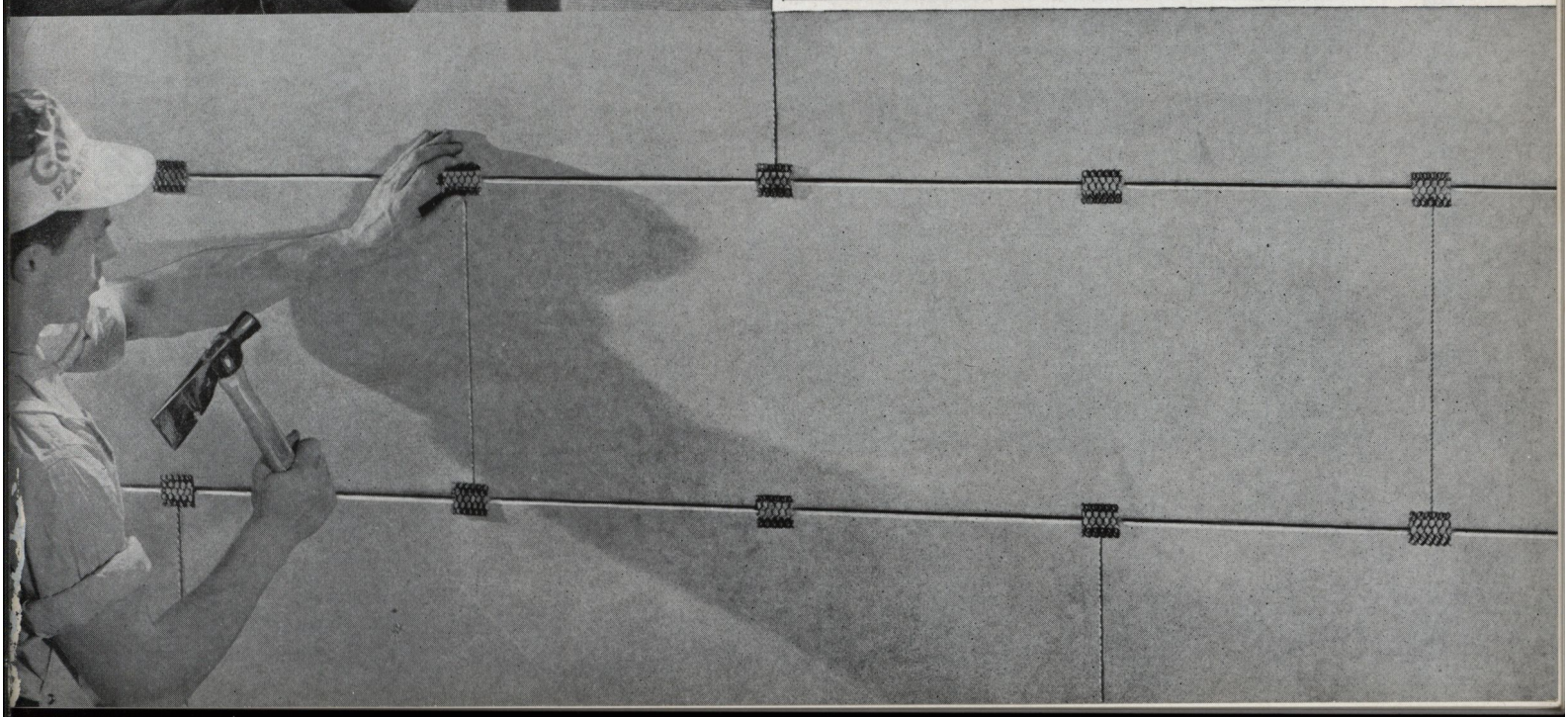
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GYPSUM LATH
With Aluminum Foil Insulation



GOLD BOND STANDARD GYPSUM LATH

The Modern Plaster Base with Core of Solid Gypsum Builds Stronger Walls and Ceilings

GOLD BOND GYPSUM LATH is made under the same exclusive patents as Gold Bond Gypsum Wallboard, the only difference being that the sizes are smaller and the gypsum core is encased in a heavy fibre sheet that bonds tightly with plaster. The long sides have closed edges and are round, as illustrated. The short ends are cut perfectly square.

Superior Bond to Plaster

The bond of plaster to Gold Bond Gypsum Lath is not dependent on mechanical keys but is obtained by the felting action of billions of gypsum crystals in the set plaster embedding themselves onto the surface of the Gold Bond Gypsum Lath during the setting action. Authoritative tests have shown this bond to be four times as great as any mechanical bond such as that obtained on wood lath, metal lath, etc.

Fireproof . . . Adds Structural Strength

The solid gypsum core of Gold Bond is non-inflammable and non-combustible. In repeated blow-torch tests, has demonstrated its ability to resist fire. Numerous testimonial letters have been received telling how effectively Gold Bond has withstood scorching flames and prevented the spread of fire by protecting the wood studs.

The strength and rigidity imparted to walls and ceilings by the use of Gold Bond Gypsum Lath adds considerably to the structural strength of the building as a whole. When covered with ½ inch of plaster, it makes a wall ⅞ inch thick . . . solid gypsum rock.

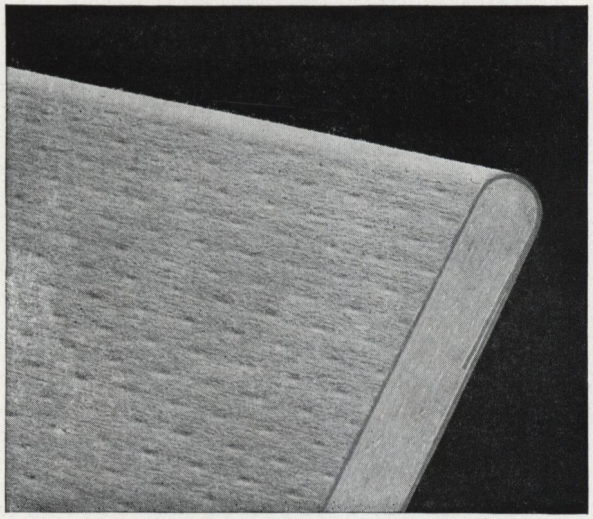
Won't Warp or Buckle—Saves Plaster Cracks

Gold Bond Gypsum Lath will not expand, contract, warp or buckle. One of the chief reasons for plaster cracking is the twisting or warping of the lath. This can't happen with Gold Bond as the rock-like panels lay perfectly flat and are not affected by dampness or climatic changes.

Cuts Labor Cost and Saves Plaster

With wood lath, spaces are left between the laths and much of the plaster goes into these spaces to form "keys." No "keys" are required with Gold Bond. The sturdy panels are butted together and *all* the plaster goes on the surface of the lath. This saving of plaster is considerable on a house of average size.

Application costs are cut, too, as the large panels of Gold Bond are applied much quicker than the narrow wood lath strips. Only 16 nails are needed to a 16″ x 48″ panel—4 nails to each stud.



Showing the distinctive indented surface of Gold Bond Gypsum Lath. The solid gypsum core is encased in this tough fibre covering.

Sizes and Thicknesses

⅜″ Thick	16″ x 32″	6 panels per bdle.	21⅓ sq. ft.
⅜″ Thick	16″ x 36″	6 panels per bdle.	24 sq. ft.
⅜″ Thick	16″ x 48″	6 panels per bdle.	32 sq. ft.
½″ Thick	16″ x 32″	6 panels per bdle.	21⅓ sq. ft.
½″ Thick	16″ x 36″	6 panels per bdle.	24 sq. ft.
½″ Thick	16″ x 48″	6 panels per bdle.	32 sq. ft.

Also made under the name Gold Bond Liner Board with non-indented surface. . . Thicknesses of ¼″, ⅜″ and ½″. Sizes of 24″ x 48″, 32″ x 36″ and 32″ x 48″.

Gold Bond Gypsum Lath comes in handy bundles that are light and easy to handle. A bundle of 16″ x 48″ x ⅜″ contains 6 panels.



For Gold Bond Gypsum Lath with Aluminum Foil Insulation, See File Index.

GOLD BOND PERFORATED GYPSUM LATH

Embodies All the Advantages of Standard Gypsum Lath *Plus* a One Hour Fire Rating for Walls

Provides Fire Protection for Wood Frame Buildings

GOLD BOND PERFORATED GYPSUM LATH is standard lath with holes about the size of a nickel drilled through the panels. When the surface is plastered, enough of the plaster is forced through the perforations to form mushroom-like "keys" as pictured in the next column. Insures a double bond with plaster—the natural or chemical bond that occurs between the indented surface of the lath and the plaster, plus the mechanical bond provided by the "keys."

Official tests conducted according to regulations of American Standards Association have shown Gold Bond Perforated Gypsum Lath to have qualified for a one hour fire rating for walls, when plastered in the standard manner. This means under normal conditions a fire will be confined to the room in which it originates for one full hour—long enough for fire apparatus to arrive.

Staggered Arrangement of Perforations Insures Greater Strength

As shown in the illustrations, the perforations are so arranged that there are not more than three holes across the width of the panel. This is strictly a Gold Bond feature and makes this lath the strongest of its type.

Other Advantages That Combine to Make This an Outstanding Plaster Base

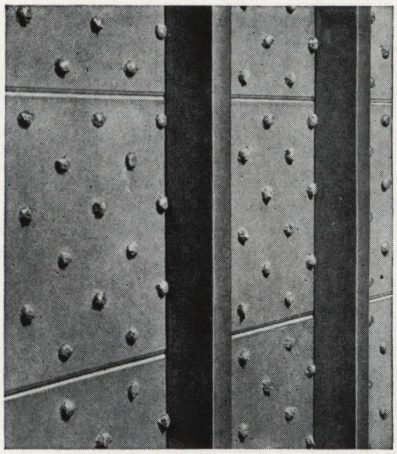
In addition to its one-hour fire rating, Gold Bond Perforated Gypsum Lath offers these important advantages over old-style inflammable wood lath: It is moisture proof and unaffected by climate changes. Won't expand, contract, buckle or twist. The rock-like panels add greater strength so that the plaster walls and ceilings are better able to withstand structural strains. Homes in which this fireproof modern plaster base is used have an extra appeal to prospective buyers.

Application

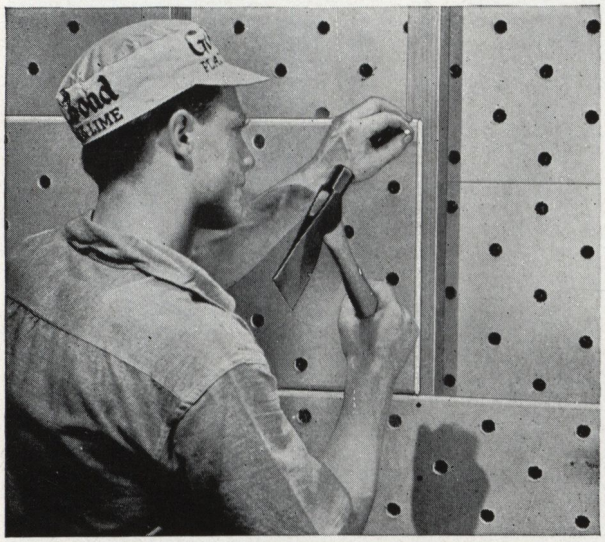
Gold Bond Perforated Gypsum Lath is applied the same as standard gypsum lath . . . four nails to each stud—the nails to be 4 in. apart and ⅜ in. in from edge.

Size and Thickness

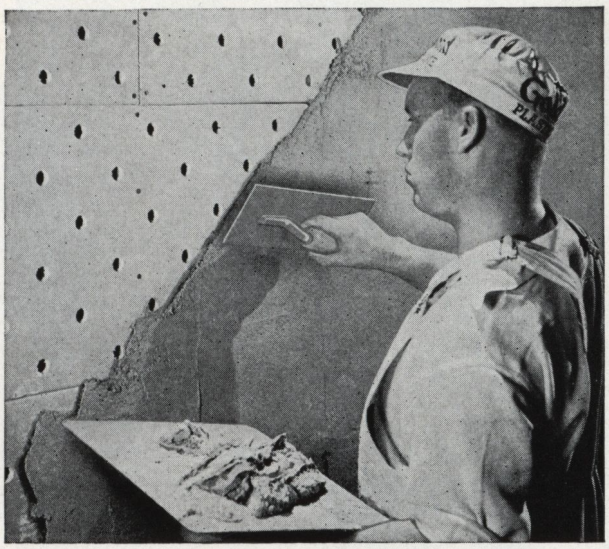
Gold Bond Perforated Lath is ⅜ in. thick and supplied in two sizes, 16x32 in. and 16x48 in. Packed 6 panels to a bundle.



Mushroom-like keys automatically form on the reverse side which grip the lath tightly.



Sturdy, rock-like panels of Gold Bond Perforated Gypsum Lath are applied quicker than wood lath and give wood framing the fire protection it needs.



As the plaster is trowelled on the workman can feel the perforations take hold. The small picture above shows what actually happens on the reverse side of the lath.

NATIONAL GYPSUM COMPANY

THE GOLD BOND "FLOATING WALL" SYSTEM

A New Patented Method of Building Walls and Ceilings With "Free Action" to Withstand Structural Strains and Vibrations Cuts Room-to-Room Noise . . . One Hour Fire Rating for Walls

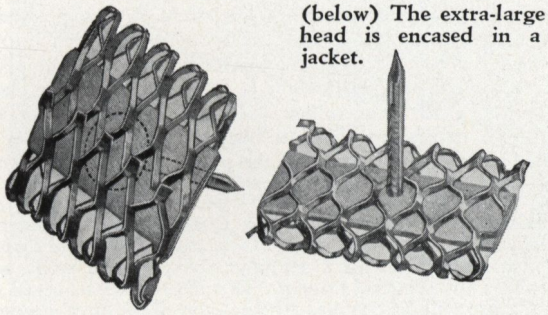
THE GOLD BOND "Floating Wall" System promises to completely revolutionize old-time methods. It provides the three all-important features of better wall and ceiling construction so much desired by every home builder but previously denied because of prohibitive cost.

The entire system is built around a new type of lath nail—the "Floating Wall" nail—a large headed nail, with the head encased in deadening felt in such a way as to provide resiliency . . . then reinforced with a double thickness of expanded metal . . . and the whole fabricated into one convenient unit for the lather. These special nails are used *between* the panels of Gold Bond Gypsum Lath, building an elastic "Floating Wall," free from rigid attachments to framing members. No plaster can touch the head of nail . . . no direct metallic contact between plaster and wood framing.

Provides New Features Never Before Obtainable in Moderately Priced Homes

The Gold Bond "Floating Wall" System insures these added advantages: (1) The danger of plaster cracks occurring from vibration or settling of the building is practically eliminated. (2) Sound transmission from one room to another is effectively checked. (3) One hour fire protection is provided for the wood framing. Heretofore, only hotels, fine buildings and the better class of apartments could boast of these features. Now they can be built into homes in every price class from a $2,500 cottage to a $60,000 mansion.

The "Floating Wall" Nail



(below) The extra-large nail head is encased in a felt jacket.

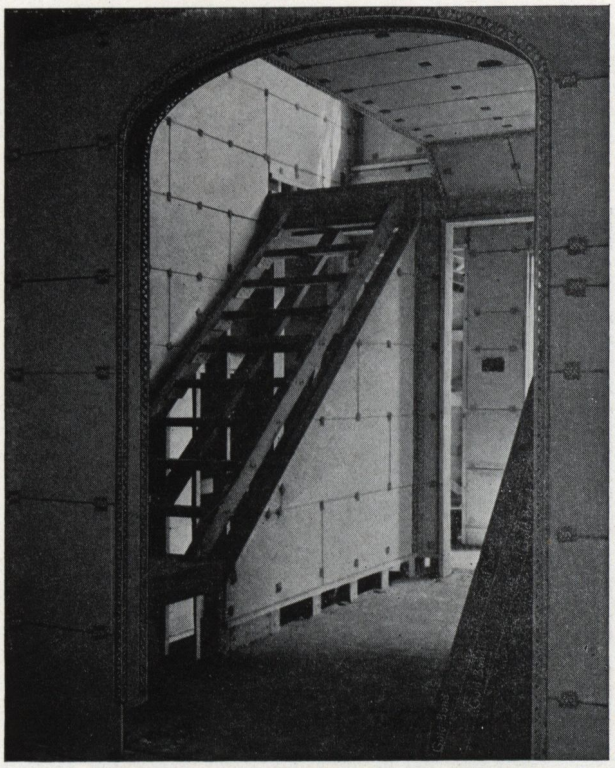
(above—left) Showing the felt covered by the metal reinforcing with the large head of the nail dotted in.

Added Cost Per Home Is Only a Few Dollars

No special skill is required to erect walls and ceilings by this new method. Lathers get the "hang" of it in a few minutes and if anything, labor cost is less. The only special material required is the "Floating Wall" nails. They cost a little more than standard nails but only four "Floating Wall" nails are used along edge of each 48 in. gypsum lath panel, as compared with sixteen nails per panel under the former method.



The "Floating Wall" Nails are driven *between* the panels of gypsum lath.



A typical "Floating Wall" job ready for plastering in the regular manner.

The Gold Bond "Floating Wall" System (Continued)

(1) Provides Resiliency . . . Lessens the Danger of Plaster Cracks

The chief reason for plaster cracks is the natural movement of framing members. There is no way to avoid this movement which in most cases is almost imperceptible. What the "Floating Wall" does is to get around the motion, so that although it still exists, it can do no harm to the plaster wall or ceiling.

Under normal conditions, with a completely rigid tie to the studs and joists, the twisting or warping of the framing members of even a few thousandths of an inch can result in plaster cracks. The "Floating Wall" system provides a resilient tie between the stud and the plaster itself. In effect the wall actually "floats" although strong and rigid and outwardly no different in appearance than a wall of conventional construction.

Months of careful testing in the Gold Bond Laboratories and systematic checking of actual jobs prove the "Floating Wall" system is crack resistant almost beyond belief. In a typical deflection test, a series of identical wall areas were built with wood lath, gypsum lath and the Gold Bond "Floating Wall" System; then plastered under standard specifications. At 1/8 in. deflection, the first crack appeared in the plaster over wood lath. Over Gypsum lath, cracks appeared at a deflection of 1/4 in. Deflection of 1 3/8 in. was needed to put a hair-line crack in the "Floating Wall." As every builder knows, deflection of 1 3/8 in. is almost inconceivable on an actual job.

(2) Reduces Sound Transmission from Room to Room

Walls built to resist passage of sound from one room to another have always been impractical in standard residential construction for the same reason that crack-proof walls and fire-proof walls have been out of the question—high cost. Now, with the "Floating Wall" System, at little or no extra cost, all three features can be provided in one operation.

Sound Transmission Loss is the measure of effectiveness that a wall, ceiling or floor area retards the passage of sound through the structure. This value is measured in decibels which are simply units of sound intensity in scale of audibility.

In a test made by the National Bureau of Standards in Washington, D. C., the "Floating Wall" received an average transmission loss of 47.6 decibles. This rating reflects the amount of sound that is actually lost or dissipated—enough to completely nullify the passage of ordinary conversational sounds through a wall partition from one room to another.

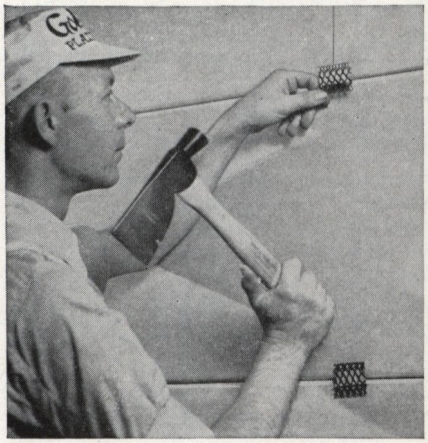
(3) One Hour Fire Rating For Walls . . . Protects Wood Framing

The chief function of "fire-proof" construction in residential building is its ability to retard the spread of fire for a reasonable length of time—long enough for fire apparatus to arrive.

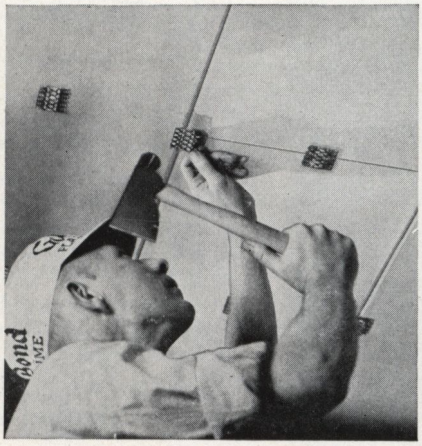
To prove the effectiveness of the "Floating Wall" construction to withstand fire, tests were conducted in a leading laboratory in accordance with standard fire test specifications, A2-1934.

A standard wood frame partition approximately 16 ft. x about 10 ft. 4 in. was constructed with Gold Bond Gypsum Lath on each side, applied with "Floating Wall" nails. Each face was finished in the regular manner with 1/2 in. Gold Bond Plaster and lime putty. During the test a load equal to the allowable working load on the net area of the wood studs was applied, totaling about 15 tons for the 16 ft. wide partition.

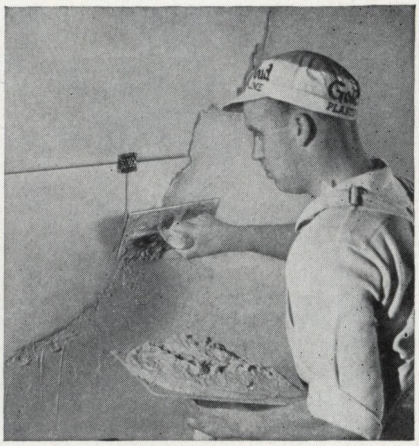
At the end of the test this "Floating Wall" was shown to have qualified for a one hour fire rating for walls under the American Standard Association regulations. This means that this type of construction can stop the spread of fire for at least one hour under normal conditions.



No special equipment needed except the "Floating Wall" nails which are sold by Gold Bond dealers along with the Gold Bond Gypsum Lath.



Lath is applied to ceilings the same as to side walls except an extra row of nails is used along the center of the panels. See detail drawing on next page.



Plastering is done in the usual manner. The expanded metal over the nail heads acts as extra reinforcing and insures uniform thickness of plaster.

NATIONAL GYPSUM COMPANY

The Gold Bond "Floating Wall" System (Continued)

STANDARD SPECIFICATIONS

Scope of Work

Gold Bond "Floating Wall" System shall be used in the following locations:

(List)

Examination of Framing Structure

Lather shall examine all framing for accuracy and proper nailing before applying lath. Openings shall be framed and electrical outlets properly located. Any defects shall be reported to architect and no lathing shall be done until such defects have been corrected.

Material

1. All materials shall be manufactured by the National Gypsum Company and shall be delivered to the job in their original containers.

2. Lath—Gold Bond Gypsum Lath (16 in. x 48 in. x ⅜ in. thick).

3. Nails—Gold Bond "Floating Wall" nails shall be used exclusively.

4. Joint Reinforcing—Gold Bond Galvanized Corner Bead for external angles. Gold Bond 3 in. Cornerite for internal angles.

5. Plaster

a. *Base Coat*—Gold Bond Plaster (specify type).

b. *Finish*—Gold Bond Finish Lime with Gold Bond Superwhite Gauging Plaster. Alternates—Gold Bond Smooth Trowel Finish, Gold Bond Sand Float Finish, Gold Bond Color Texture.

Application

1. All walls, ceilings, and partitions as specified shall be covered with Gold Bond Gypsum Lath.

2. Lath shall be applied with back of lath facing stud, joists or furring, taking care to break joints. Vertical joints shall not occur opposite each other on same stud.

3. Lath shall be cut by scoring with a knife or hatchet and then break over a straight edge.

4. Lath (16 in. x 48 in.) shall be nailed to sidewalls with four "Floating Wall" nails driven in the joints between the lath at each stud. Ceilings shall be nailed as above together with one "Floating Wall" nail driven midway between folded edges at each joist or furring strip. Core of boards shall be ruptured with point of lather's hatchet where "Floating Wall" nails are not placed in between joints.

5. Any openings for outlet boxes, etc., shall be clean and neatly fitted to proper sizes and location.

Reinforcing Angles

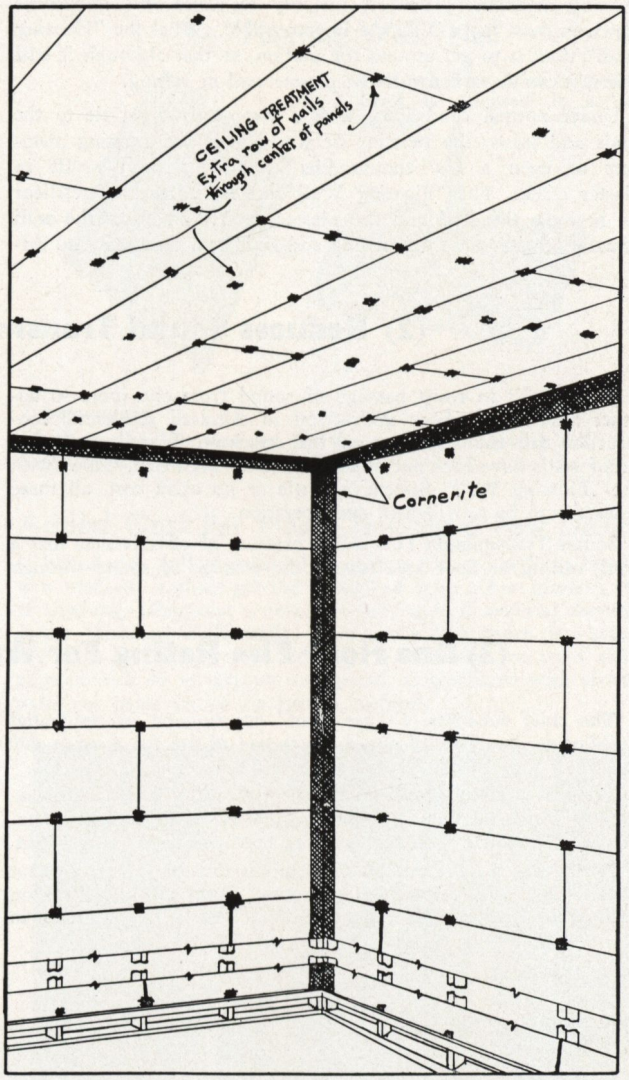
1. All internal angles of walls and ceilings shall be reinforced with Gold Bond 3 in. Cornerite and securely nailed.

2. All external angles shall be reinforced with Gold Bond Corner Bead (specify style) securely nailed.

Plastering

Follow standard specifications for plastering over gypsum lath. Plaster shall be full ½ in. thick.

Showing Wall and Ceiling Placing of Gold Bond "Floating Wall" Nails



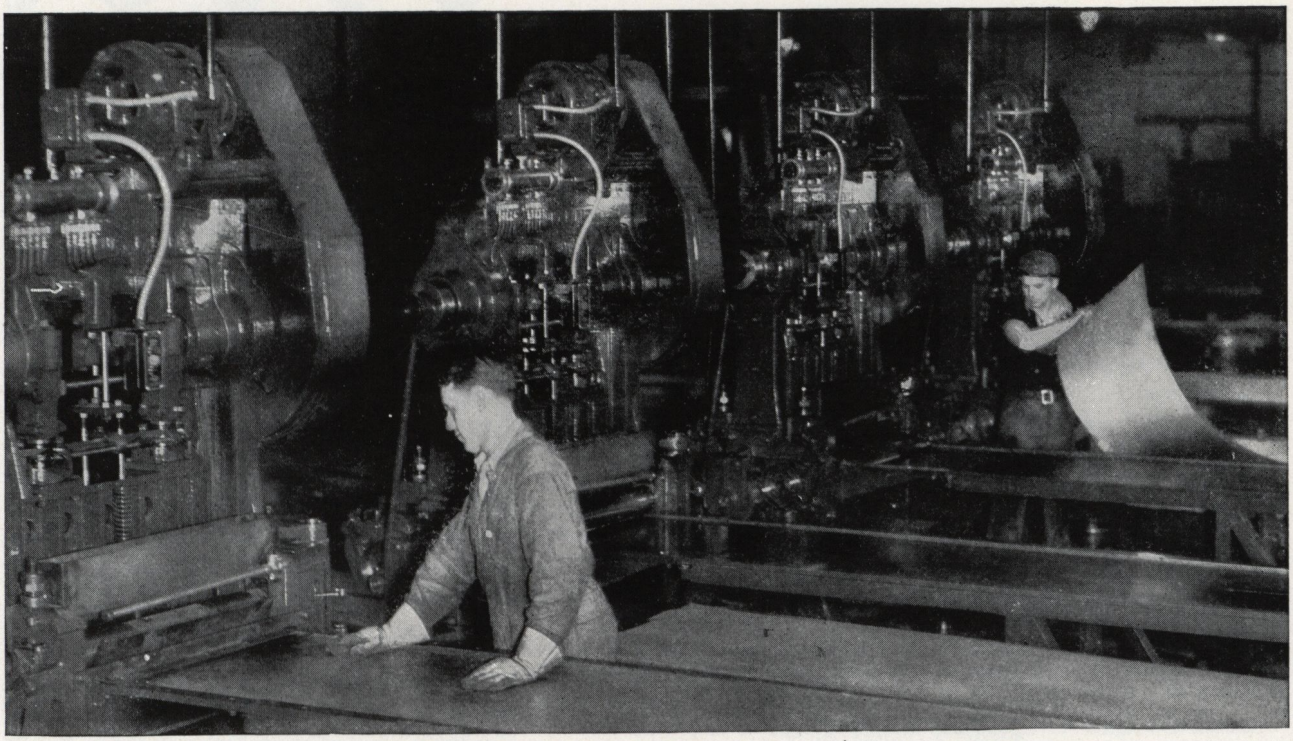
Wall Treatment—Four "Floating Wall" Nails are used along the 48 in. side of each panel of Gold Bond Gypsum Lath.

Ceiling Treatment—Same as for walls except there is an extra row of nails along the center of the lath panels (as indicated by arrows in above drawing), one center nail to each stud. The lath should be punctured with point of lather's hatchet to provide holes for the center nails.

Internal corners should be reinforced with 3 in. Gold Bond Cornerite. External corners should be covered with Gold Bond Corner Bead.

Patented and Exclusive to Gold Bond

The Gold Bond "Floating Wall" System is patented and available only through bona fide Gold Bond dealers . . . Upon request, National Gypsum Company will send, gratis, an illustrated book describing this system in detail.



Making the New Style Flat Rib Lath at Gold Bond's Metal Lath Plant in Niles, Ohio

GOLD BOND METAL LATH PRODUCTS

Most Gold Bond Metal Lath Products Are Made From Steel Sheets Manufactured by the Open Hearth Process

NATIONAL GYPSUM COMPANY manufactures at its Niles, Ohio plant a full line of metal lath products and accessories.

For years metal lath, because of its unmatched strength and one hour fire rating for both walls and ceilings, has been invariably specified as the plaster base for buildings and the better class of homes. Lately it has come into common use for all types of residences including homes costing as little as $4,000. As one expert puts it, "Savings realized on repair and decorating bills over the years are every bit as important to owners of small homes as to those who own mansions."

The National Board of Fire Underwriters gives Metal Lath with gypsum plaster on wood studs a one hour fire rating; second only to reinforced concrete and above all others in resistance to earthquake and explosion shocks.

Only a few of the most commonly used products are pictured here, including the new Arch Corner Bead, an exclusive Gold Bond feature. Other products are: Corner Beads (5 in. Wing, Expansion, Scalloped, Wide Flange, Standard Bull Nose and Bull Nose Expansion), Base Beads (Curved Point and Expansion Flush), Corner Bead Clips and Channel Clips, Hot Rolled Channels, Galvanized Tie Wire, Pencil Rods, Coal Doors and Steel Basement Sash.

An illustrated catalog describing the complete line will gladly be furnished by writing Metal Lath Division, NATIONAL GYPSUM COMPANY, Buffalo, N. Y.



Partitions made of Gold Bond Metal Lath and plastered in the customary way are rated by the National Board of Fire Underwriters as second only to reinforced concrete.

GOLD BOND METAL LATH

Gold Bond Small Diamond Mesh Lath

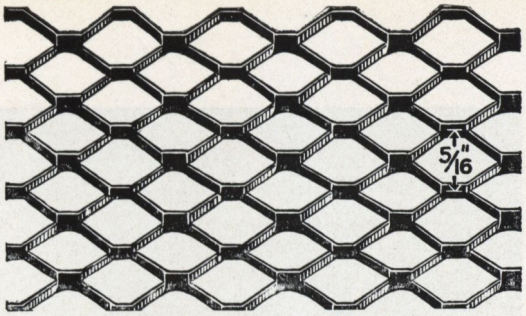
Can be used on any type of metal lath job. It constitutes better than 50% of all the metal lath sold.

Gold Bond Small Mesh boasts of having as small a mesh as any diamond mesh manufactured; containing approximately 3000 more keys per square yard than the regular ⅜ in. mesh. All sheets lay perfectly flat and each sheet has re-squared ends assuring full covering width. Regular ⅜ in. mesh can be furnished upon request. Is made from open hearth box annealed sheets.

Standard Weights—2.2, 2.5, 3.0, 3.4 lb. Furnished in painted steel, copper bearing and Armco Iron. Galvanized in 2.5 and 3.4 lb. only.

Sheet Sizes

—24 in. x 96 in. 9 sheets per bundle or 16 sq. yds.
—27 in. x 96 in. 10 sheets per bundle or 20 sq. yds.



Gold Bond Small Diamond Mesh Lath

Gold Bond 1/8-in. Flat Rib Lath

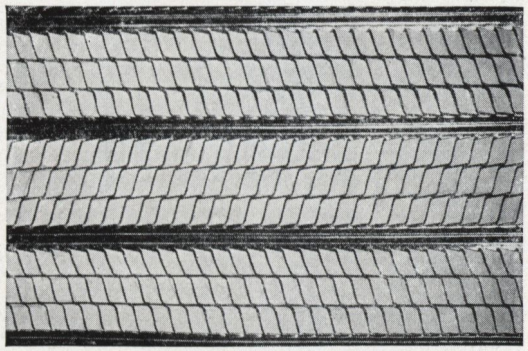
Primarily designed to meet a growing demand for a more rigid expanded metal lath, and a more economical plastering job . . . 1280 meshes to a square foot, providing more plaster keys than any other like product on the market.

Gold Bond ⅛-in. Flat Rib saves time and money in erection costs as the new size—27 x 96 in.—can be applied in exactly the same time as the usual 24 x 96 in. sheets.

Standard Weights—2.75, 3.0 and 3.4 lb. Furnished in painted steel and copper bearing steel. Galvanized in 3.4 lb. only.

Sheet Sizes

—27 in. x 96 in. 10 sheets per bundle or 20 sq. yds.
—24 in. x 96 in. 9 sheets per bundle or 16 sq. yds.


Gold Bond ⅛-in. Flat Rib Lath

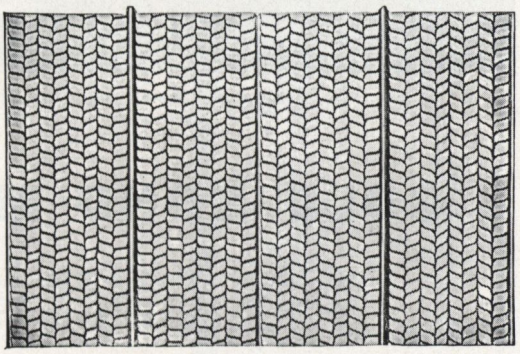
Gold Bond 3/8-in. Rib Lath

Is generally used for ceiling and for concrete reinforcing in floors in connection with steel joists, junior beams, etc.

Gold Bond ⅜ in. Rib is outstanding for its rigidity. Ribs are 4 in. on center. Sheets nest perfectly when lapping which results in a smooth surface for plastering, thereby eliminating bulges and creating a saving in plaster waste. Manufactured from open hearth box annealed sheets.

Standard Weights—2.5, 3.0, 3.4 and 4.0 lb. Furnished in painted copper bearing steel and Armco Iron. Galvanized in 3.4 lb. only.

Sheet Size—24 in. x 96 in. 9 sheets per bundle or 16 sq. yds.

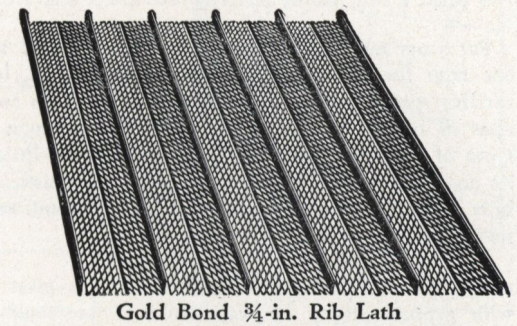

Gold Bond ⅜-in. Rib Lath

Gold Bond 3/4-in. Rib Lath

Used mainly as a form and reinforcement in concrete slab floor and roof construction. Won't bulge or sag. Ribs are spaced 4 in. on centers ¾ in. deep. . . . Also adapted for use as a plaster base in the construction of 2-in. solid partitions. Due to the rigidity and reinforcing feature of the ribs, no studs are required.

Standard Weights—.50 lb., .60 lb., .75 lb. per sq. ft. Furnished in painted steel and copper bearing steel. Galvanized in .50 lb. and .75 lb. weights. Armco or pure iron in .75 lb. weight.

Sheet Sizes—24 in. x 6, 7, 8, 9, 10, 11, 12 ft. 9 sheets per bundle.

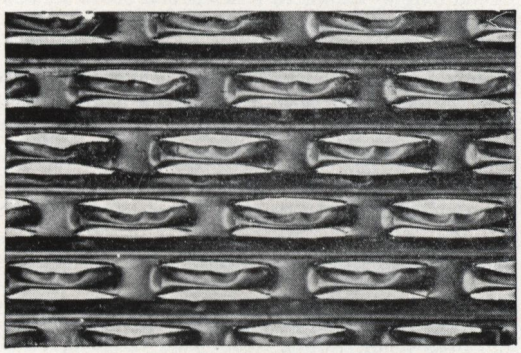

Gold Bond ¾-in. Rib Lath

Gold Bond Sheet Lath

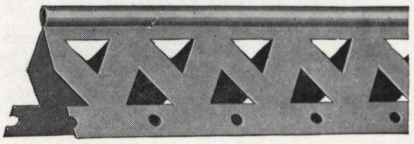
Is used generally for tile backing due to its being the most rigid lath manufactured. It requires considerably less plaster than any other type of metal lath and therefore, is often used on residences and large apartment buildings. The trough formation of the ribs creates a suction and makes it the ideal lath for overhead work on ceilings. Gold Bond Sheet Lath is of our own exclusive design. Manufactured from open hearth annealed sheets.

Standard Weights—4.5 lb. in painted and 5.5 lb. in galvanized.

Sheet Size—24 in. x 96 in. 9 sheets per bundle or 16 sq. yds.


Gold Bond Sheet Lath

GOLD BOND METAL LATH ACCESSORIES

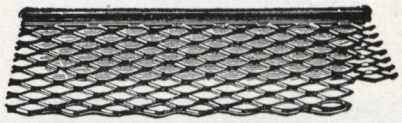


Gold Bond Arch Corner Bead

Gold Bond Arch Corner Bead

Use—Gold Bond Arch Corner Bead is the all-purpose corner bead. Used for vertical and horizontal corners or may be easily bent for arches. Full description on next page.

Stock Lengths—6, 7, 8, 9, 10 and 12 ft. Made in 26 gauge. 24 gauge on special order. Packed 10 pieces per bundle. Weighs 200 lbs. per 1000 lin. ft.

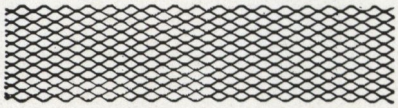


Gold Bond Standard Expansion Corner Bead

Gold Bond Standard Expansion Corner Beads

Use—Gold Bond Standard Expansion Corner Beads can be used in all types of construction. Forms an exceptionally fine key due to the reinforcing given by the 2½ in. wings. Is easily erected.

Stock Lengths—6, 7, 8, 9, 10 and 12 ft. Made in 26 gauge. 24 gauge on special order. Shipped in crates of approximately 500 or 1000 ft. only. Weighs 208 lbs. per 1000 lin. ft.

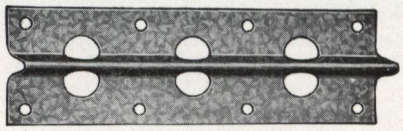


Gold Bond Stripite

Gold Bond Stripite

Use—Gold Bond Stripite is diamond mesh lath cut into strips. Used over joints, around window and door frames in construction where metal lath is not used throughout. Standard in painted steel. May be had in copper bearing or galvanized steel.

Sizes—2, 3, 4, 6 or 12 in. wide by 96 in. long. Packed 63 pieces per bundle (504 lin. ft.) 3x96 in. Stripite weighs 60 lbs. per 1000 lin. ft.

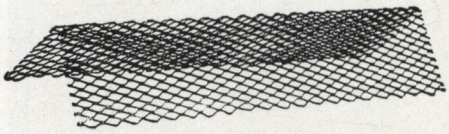


Gold Bond Standard Base Bead

Gold Bond Standard Base Bead

Use—Gold Bond Standard Base Bead is used as a ground where the cement base is to be divided from the plastered wall. Assures a straight and perfect division line. Made in both ½ and ¾ in. ground.

Stock Length—10 ft. only. 26 gauge. 10 pieces per bundle. Weighs 180 lbs. per 1000 lin. ft.

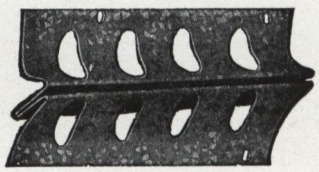


Gold Bond Cornerite

Gold Bond Cornerite

Use—Gold Bond Cornerite is diamond mesh lath cut into strips and bent to a right angle. Used in interior corners of walls and ceilings over wood lath, gypsum lath, etc. Standard in painted steel. May be had in copper bearing or galvanized steel.

Sizes—2, 3, 4, 6 or 12 in. wide by 96 in. long. Packed 63 pieces per bundle (504 lin. ft.) 3x96 in. Cornerite weighs 125 lbs. per 1000 lin. ft.



Gold Bond Picture Mould

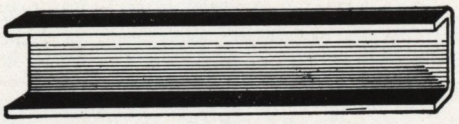
Gold Bond Picture Mould

Gold Bond Picture Mould is a metal concealed picture moulding. It is erected before walls are plastered and is absolutely invisible when wall is finished.

Stock Length—10 ft. only. 26 gauge. 10 pieces per bundle. Weighs 230 lbs. per 1000 lin. ft.

GOLD BOND METAL LATH PRODUCTS

Gold Bond Cold Rolled Channels



Are used generally for suspended ceiling work and 2 in. solid partitions. They are formed cold from the best quality strip steel. Gold Bond Channels are absolutely straight and are especially adaptable to form work because of their bending qualities and rigidity.

Type	Stock lengths shown in feet	Packed Pcs. per bdle.	Weight, Lbs. 1000 lin. ft.
Pencil	12, 14	20	113
Box	16, 18, 20	20	276
¾ in.	16, 18, 20	20	276
1 in.	16, 18, 20	20	332
1½ in.	16, 18, 20	10	442
2 in.	16, 18, 20	10	553

Furnished unpainted unless otherwise specified. Pencil Channel always furnished in painted stock.

Gold Bond Metal Arches

Are made from galvannealed sheet steel. A perfect arch for approximately half the cost of curved wood forms to which must be fitted corner bead and metal lath. They are easy to erect and are ideal for residences and apartment houses. Gold Bond Metal Arches are made in true circle, gothic and elliptic designs. They are standard for 2x4 studs or bucks. The studs or bucks are to be spaced 1½ in. wider than the desired finished opening.

This allowance is for the thickness of the lath and plaster ground. Can be jointed with standard corner bead by using the shank of a No. 7 box nail.

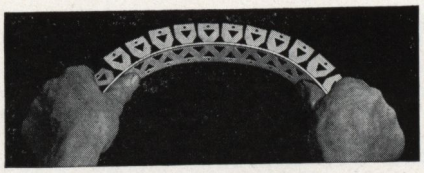
Styles and Erection Details

Style of Arch	Spacing of Studs or Bucks	Width of Finished Opening	Height from Spring-line to Crown
No. 11	21½″	20″	10″
No. 22	33″	31½″	15¾″
No. 33	33″	31½″	11⅜″
No. 44	51″	49½″	12½″
No. 55	63″	61½″	13″
No. 66	72″	70½″	13″

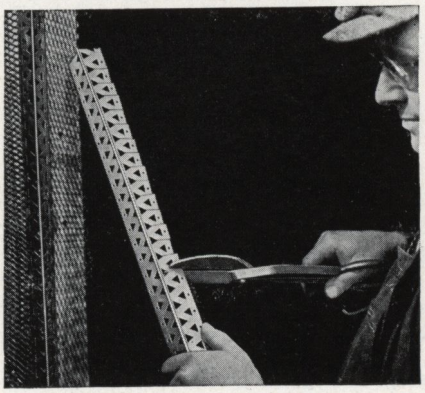


Gold Bond Metal Arches are easily fitted over the lath. Saves time and insures perfectly formed arches.

Gold Bond Arch Corner Bead



Won't Kink or Break

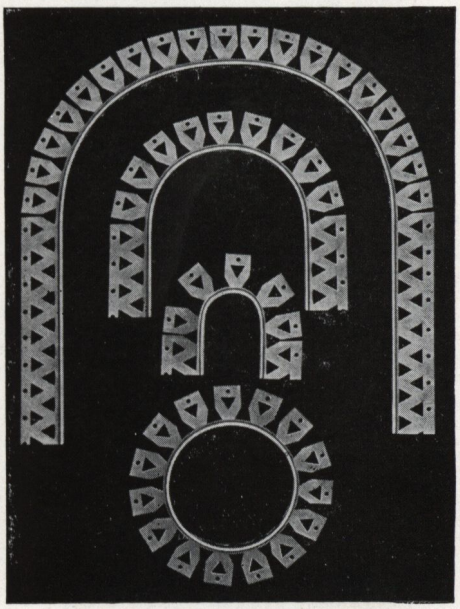


Easily Prepared for Bending

A new product, Gold Bond Arch Corner Bead has met with instant acceptance among builders and dealers. Serves a double purpose—as a corner bead for vertical or horizontal corners—as an arch bead for curved openings. Arches can be quickly made on the job at a decided saving.

Ordinary corner beads invariably break or kink at the nose when bent. Not so with Gold Bond Arch Corner Bead because its unique design permits utmost flexibility. No mechanical bender is necessary. Simply snip one flange as illustrated at the left and bend to the desired radius. Fits over any style of lath. The flanges have twice as many perforations as most corner beads which means more plaster "keys" and greater bonding strength.

Supplied in lengths of 6, 7, 8, 9, 10 and 12 ft. Made in 26 gauge. 24 gauge on special order. Packed 10 pieces per bundle. Weighs 200 lbs. per 1000 lineal ft.



For Ornamental Plaster Work

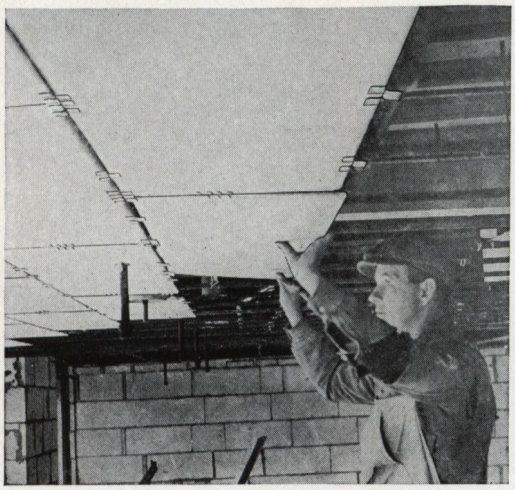
GOLD BOND "CLIP-ON" SYSTEMS For Suspended Ceilings and 2-inch Solid Partitions

Two Patented Systems Which Combine the Use of Gold Bond Gypsum Lath and Metal Installation Clips . . . Quicker, Stronger, Cuts "Dead-Load" Weight One-Third . . . One Hour Fire Rating

SUSPENDED CEILINGS

THE important problem of keeping cracks out of suspended plaster ceilings has been approached in the most scientific and practical way in the development of the Gold Bond "Clip-On" System.

This method comprises the use of fireproof Gold Bond Gypsum Lath, galvanized copper bearing clips and standard coated channels. The channel grillage is so constructed as to permit expansion or contraction without transferring any of the resulting movement to the gypsum lath, thereby eliminating the most common cause for plaster cracks.



The panels of Fireproof Gold Bond Gypsum Lath slide into the metal clips and the job moves along like clock-work. Lathers get the "hang" of it quickly.

Stronger and Lighter

In accomplishing this freedom for expansion or contraction there is no sacrifice of strength or other desirable qualities of good ceiling construction. The Gold Bond "Clip-On" System builds the strongest ceiling of any known method. This outstanding strength is provided despite the fact that the weight of the ceiling is 20 to 30% less than usual. The "Clip-On" System weighs 45 to 50 pounds per square yard in contrast to the normal weight of 70 to 80 pounds.

One-Hour Fire Rating

The Gold Bond "Clip-On" Suspended Ceiling when plastered according to specifications, fully meets the standard one-hour fire test imposed by the fire underwriters.

Speedy Installation

Contractors find the "Clip-On" System easy to master and a real time-saver. One distinct saving—furring channels are spaced at 16-inch intervals instead of the customary 12-inch. This alone represents a saving of 25% in channels and erection labor.

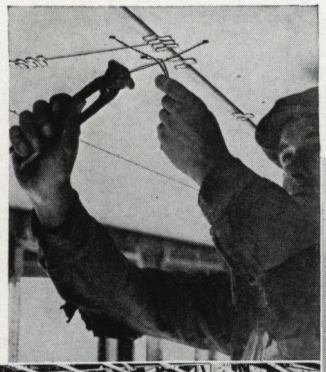
The sturdy panels of Gold Bond System Lath, 16 x 48 inches, are easily clipped into place and provide a smooth, even base for plaster. Actual figures show that the plasterer will apply greater yardage per day than over any other type of plaster base.

Complete Gold Bond "Clip-On" Ceiling

The Gold Bond "Clip-On" System is designed and sold for use with Gold Bond Gypsum Lath, plastered with Gold Bond Gypsum Plaster and finished with Gold Bond Finish Lime. In specifying the system with Gold Bond Products throughout, the architect or engineer is protected by one undivided manufacturing responsibility.

Descriptive Book on Request

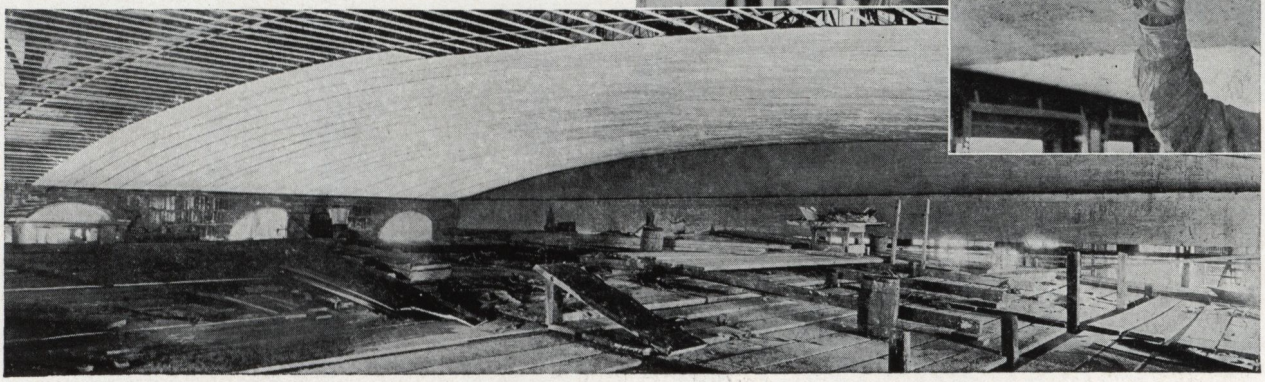
National Gypsum Company will gladly send without charge, an illustrated book "Gold Bond 'Clip-On' System for Suspended Ceilings."



(left) Toggles are used on ceiling areas over 12 ft. square.

(below) Plasterers can work faster over this smooth base.





NATIONAL GYPSUM COMPANY

"CLIP-ON" SYSTEMS (Continued)

2 INCH SOLID PARTITIONS

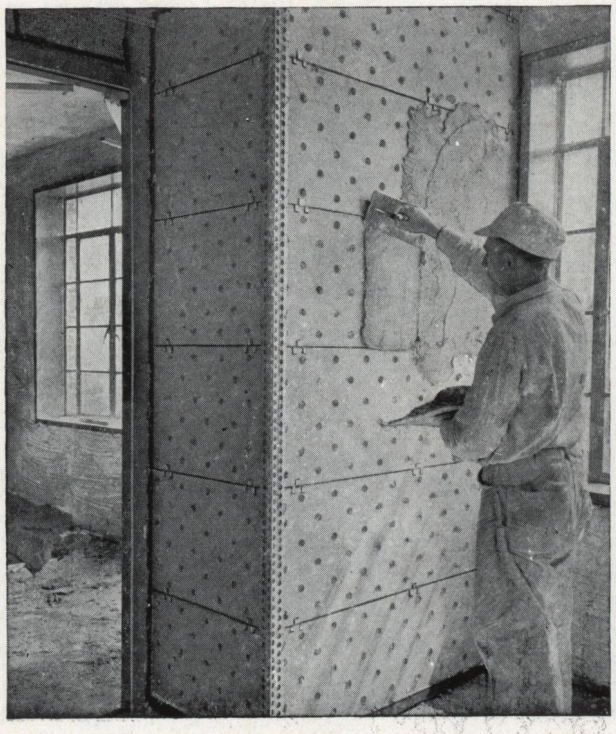
THE GOLD BOND "Clip-On" 2-Inch Solid Partition provides a thin but very sturdy construction adaptable to hotels, apartment houses, office buildings, and especially to low-cost housing developments. Saves a full 2½ inches in width or length of a room as compared with conventional wood stud partitions, plastered on both sides. It also speeds up completion of the job at a decided saving in labor and material.

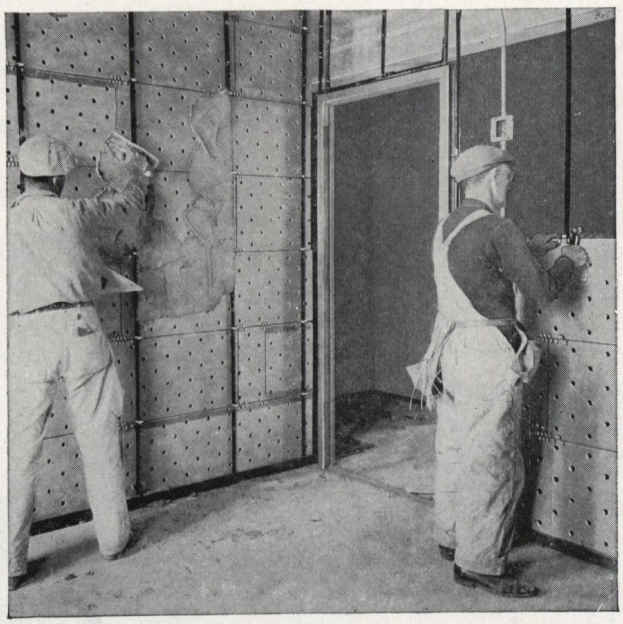
This system comprises the use of Gold Bond Perforated Gypsum Lath, galvanized copper bearings clips, and standard coated channels. Erection is rapid. Channels are spaced 24 inches on centers (or 16 inches); the gypsum lath panels 16 x 48 inches dropped into place and one sharp blow anchors the lath clips to channels. The job is then ready for plastering. As shown by the following chart, a saving of two days' time per room is effected.

DAY	2-IN. "CLIP-ON" SYSTEM	OTHER 2-IN. SYSTEMS
First	Lather erects channel studding and "clips-on" Gold Bond Gypsum Lath.	Lather erects channel studding and plaster base.
Second	Plasterer "backs up" channel studding area with scratch coat and also applies brown coat to gypsum lath side, and double backs with brown coat on channel side.	Scratch coat applied to metal plaster base. (This operation is entirely eliminated with the "Clip-On" System.)
Third	Finish coats, both sides.	Backs up channel side with fill coat.
Fourth		Brown coat on both sides.
Fifth		Finish coat on both sides.

One-Hour Fire Rating

The Gold Bond "Clip-On" Partition fully meets the requirements for a one-hour fire test rating. Not only is it a highly incombustible wall, but it provides real protection against spread of fire. As there is no wood studding, high temperatures cannot start combustion within the wall itself.





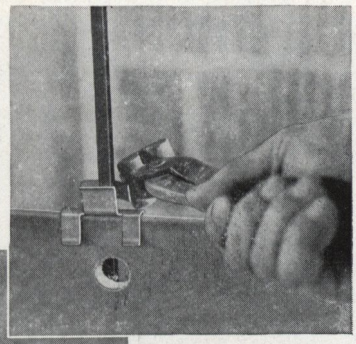
Plasterer (at left) filling in the channel side with the scratch coat. Lather (at right) builds up the partition quickly.

Other Advantages

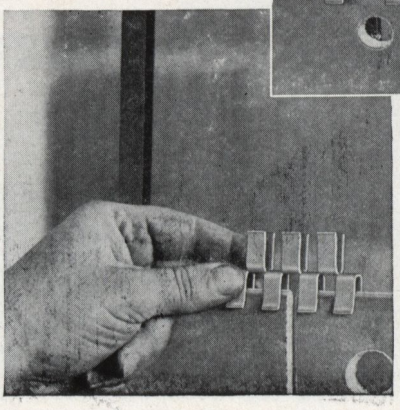
The "Clip-On" System builds a 2 inch solid partition of extreme strength, yet remarkably light for a plaster partition. Enjoys the highest comparable rating on impact tests as conducted by the Bureau of Standards. Resiliency provided by metal clips practically eliminates danger of plaster cracks occurring from vibrations or structural strain.

Descriptive Book Available

Upon request National Gypsum Company will gladly send a large illustrated book . . . "Gold Bond 'Clip-On' System for 2 Inch Solid Partition Wall."

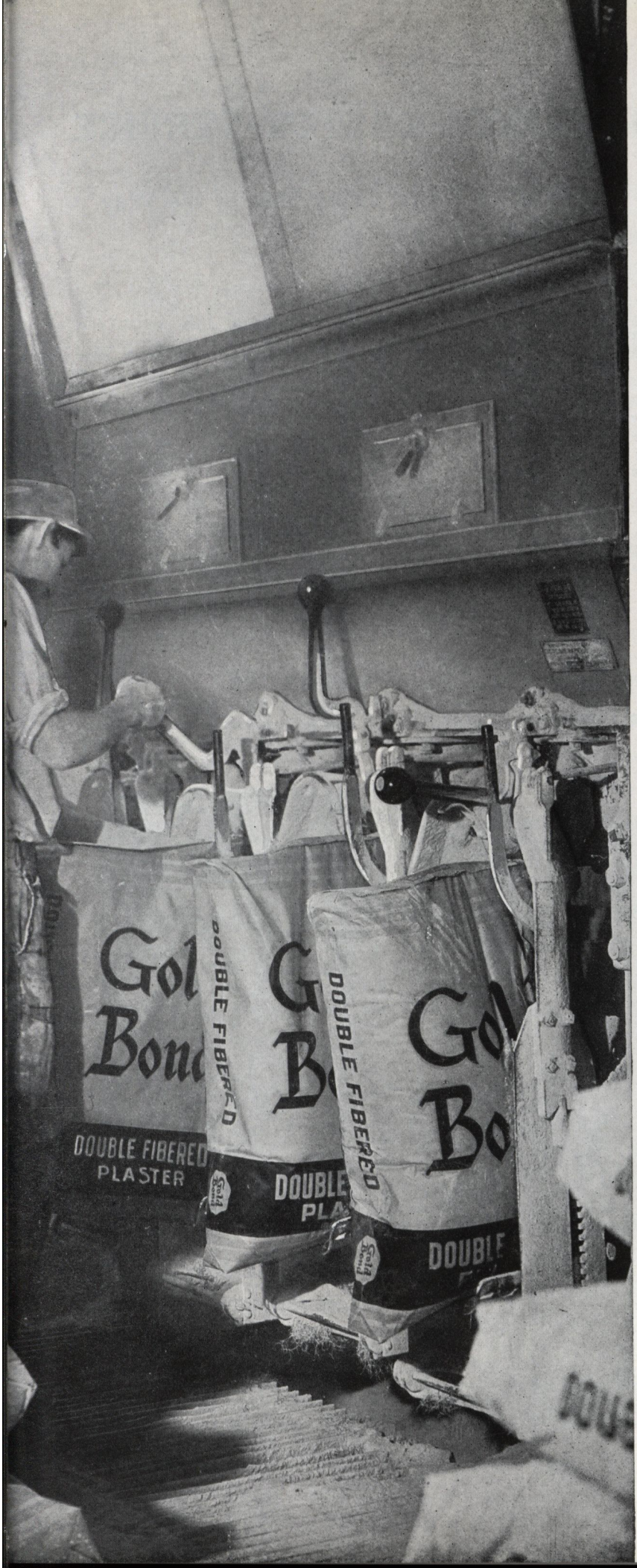


(left) Applying the "brown" coat to the face side. Plastering moves along fast over the Gold Bond Perforated Gypsum Lath.



(above) One sharp blow clinches clip No. 101 to channel.

(left) The edges of the lath panels don't have to "hit" on channels.



SECTION TWO

GOLD BOND
GYPSUM PLASTERS
LIME AND PAINT

Pages 14-15
GYPSUM PLASTERS . . . GENERAL DATA

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KEENE'S CEMENT

Page 23
FINISH and MASON'S LIME

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COLOR TEXTURE

Page 26
CASEIN PASTE PAINT

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PIGMENTED PRIMER
DEEP COLORS
LIME PROOF MORTAR COLORS

Pages 28-34
SPECIFICATIONS . . . LATH and PLASTER

See File Index
MACOUSTIC ACOUSTICAL PLASTER

At Left:

Mechanically controlled mixing and bagging equipment assure accurate blending and weighing of plaster without possibility of human error.

GOLD BOND—A COMPLETE PLASTER SERVICE

How Gold Bond Supervises the Quality of Its Plaster Every Step of the Way From Mine to Finished Wall

GOLD Bond Plaster mines and quarries are located in the richest gypsum sections of the country, the vast deposits insuring approximately a hundred years' supply of exceptionally pure rock.

Purity Assured

Here in these mines and quarries daily tests are made to assure the constant purity of the rock—actual tests proving that the purity of the gypsum has a decided effect upon the strength and hardness of the finished wall. High purity also increases the coverage and smooth working qualities of the finished plaster.

Gold Bond spares no trouble or expense to obtain the purest gypsum rock, and then follows it by laboratory tests through every process of manufacture to the finished job.

Tested for Individual Job

For this purpose—suiting the plaster to the individual job—the Gold Bond laboratories are constantly testing specimens of sand from every part of the country where Gold Bond plaster is used. Samples are continually being secured to meet changes in local conditions.

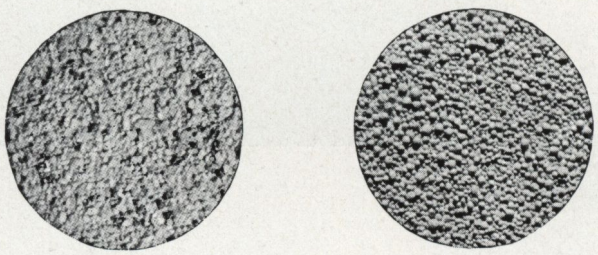
Before shipping, every batch of plaster is tested to meet the requirements of the particular sand of the vicinity into which the plaster is to be shipped. A somewhat costly process from the viewpoint of the manufacturer, but well worth the expense as it assures our customers of getting plaster that is particularly suited to their respective territories regardless of any unusual local conditions. New processes (patent applied for) insures uniformity of performance under all normal job variations and weather conditions.

Introduction of the new Gold Bond Microplastic Plaster in 1935 proves one of the greatest improvements in plaster history

Gold Bond Plasters have long been accepted as "standard" among the leading contractors of the country. Then in 1935, this enviable position was greatly enhanced by the introduction of a brand new plaster—Gold Bond Microplastic Plaster, produced after years of intensive research work.

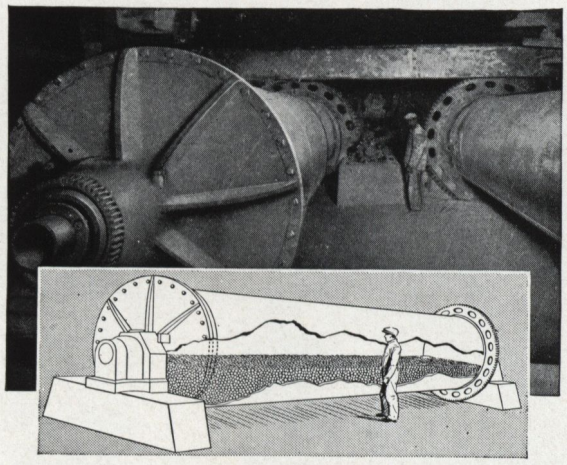
This improved method of processing has resulted in a product that is practically foolproof as far as application is concerned. Plasticity or workability has been increased 100% with far greater coverage. The new Gold Bond Microplastic Plaster met with instant approval and experts considered this to be the greatest forward step in the development of plaster in many years.

What the Micron-Sizing Process Actually Accomplishes



Before — After

Note the contrast between these microphotos. At the left the plaster is coarse and flinty, while at the right the plaster after the Micron-Sizing Process has been broken down into millions of tiny particles and then rolled into soft, felted balls.



New Equipment and New Processes Enable Gold Bond to Offer a New High Quality in Plaster

Two of the huge revolving mills which regrind the gypsum particles into micron sizes and roll them into soft felted balls.

Bottom: An X-ray drawing of interior of mill showing the 100,000 manganese steel balls which do the pulverizing.

Scientific Principle of Micron Sizes and Their Effect on Plasticity

It is a well established scientific principle that in the setting of plaster a gelatinous plastic film is produced on the surface of the particles of calcined gypsum. Gold Bond, as one step in manufacture, regrinds the particles to micron sizes (1/25,000 inch). The enormous increase in area resulting greatly multiplies the bulky gelatinous smooth working qualities.

GENERAL DATA

Characteristics and Application of Gold Bond Gypsum Plasters

The high grade gypsum rock used in the manufacture of all Gold Bond Plasters is hydrated calcium sulphate, containing approximately 20% of chemically combined water. In the calcination process most of this water is driven off, producing "plaster of Paris" which is the base of all gypsum plasters. On remixing with water on the job, the material takes back the water driven off in calcination and crystallizes or sets to the original gypsum rock.

In making Gold Bond Gypsum Plasters, small amounts of other materials are added to the basic "plaster of Paris" to control the time of set, working qualities, type of use, and particular market conditions of territory to which it is shipped.

May Be Used on All Plastering Bases

One of the many advantages of gypsum plaster is that it may be used on all types of plastering bases in addition to masonry surfaces. It may be used on gypsum, wood or metal lath; clay, concrete or gypsum tile or blocks; brick, concrete or other standard masonry plastering surface.

Adhesion Qualities

The particularly strong adhesive quality of gypsum plaster has been practically demonstrated in tests at the U. S. Bureau of Standards. It was conclusively shown that it does not depend entirely on mechanical keys but bonds on actual suction or adhesive qualities.

Dries Quickly

The advantages of the quick set and rapid drying qualities of gypsum plaster are very important in the completion of a building as well as reducing overhead. The usual time for a hard set is from 2 to 6 hours and complete drying in about 36 hours depending on weather and the season of the year. After drying there is no further sweating or dampness.

Durability

Gypsum plaster forms a hard, tough base for the application of finish coats or decoration. The tough base coats help the plaster wall to withstand rough usage which it may receive during the life of the building.

Low Coefficient of Expansion

After being applied, gypsum plaster remains inert and does not expand or contract even when subjected to fire. As it is made of gypsum it is absolutely incombustible.

Packaging

Shipped usually in 100 lb. paper bags; and some specialty products in 250 lb. barrels.



At Left:
Gypsum Mine at Clarence Center, N. Y.



At Right:
Gypsum Quarry at National City, Mich.

GLOSSARY OF TERMS AND INFORMATION REGARDING PLASTERS AND THEIR USES

In view of the use of numerous local or descriptive names for the same type of plaster and widely varying market practices, it is felt that the following classification of plasters as to names and uses will be of considerable value:

BASE COAT PLASTERS

Cement Plasters

These plasters constitute the bulk of tonnage of all types of gypsum plasters used. The term relates to all Neat (the term Neat designating a plaster containing no sand or other aggregate added at mill) plasters either with or without hair or sisal fiber. (Wood Fiber Plaster is never classified as a cement plaster.)

Cement plaster is also called by the following names in many markets:

(a) Hardwall
(b) Patent Plaster
(c) Neat
(d) Compound
(e) Paristone
(f) Base Coat Plaster

Fibered and Unfibered Cement Plaster

Hair Fibered Plaster—

Hair Fibered Plaster may contain either hair or sisal fiber. Sisal fiber is recommended as being more satisfactory than hair in plaster.

Unfibered Plaster—

This designates only cement plaster containing no fiber.

Uses for Cement Plaster—

This material is generally used for plaster work where good plaster sand is easily available and it is economically advisable to mix sand on the job rather than use a mill-mixed material. Cement Plaster is formulated for use with sand in amounts covered in directions and *should never be used Neat*—i.e., without addition of sand.

Sanded Plaster

This material is the same as Cement Plaster, except that a properly graded sand has been added at the mill in the proper amount for best plastering results. It has been called by many names listed under Cement Plaster except with the term Sanded used in addition.

Uses for Sanded Plaster—

This material is used largely where good plastering sand is not easily available, where absolute exactness of proportioning of amount of sand is required, where facilities for mixing are limited, or job is not large enough to justify trouble of mixing sand on the job. Sanded plaster is used solely with addition of water on the job.

Wood Fiber Plaster

This type of plaster contains a finely shredded wood fiber and is made primarily for use with addition of water only on the job. In some cases, however, a small amount of sand (never over one part by weight) is added on the job. In some markets this material is known as Pulp plaster.

Uses for Wood Fiber Plaster—

This material is used to a large extent for patch jobs, for work where an extremely hard wall is wanted, where base plaster is to be trowel finished, where sand is not easily available, etc.

Sanded Wood Fiber Plaster

This type plaster is on same general order as Wood Fiber Plaster except a small amount of specially graded fine sand is added. Its uses are the same as with Wood Fiber Plaster and it is used in certain markets where trade prefers a sanded wood fiber.

Concrete Bonding Plaster

This is a specially formulated wood fiber plaster to provide maximum bond to interior concrete surfaces. Ordinary gypsum or lime plaster does not bond properly to concrete surfaces. Water only is added in mixing on the job.

Bond Plaster

This material is the same as Concrete Bonding Plaster.

FINISH PLASTERS

Gauging Plaster

This is a specially ground calcined gypsum which may be either pure white or grey in color and quick or slow in set. Other names used to designate this material are as follows:

(a) Plaster of Paris
(b) Calcine
(c) Finish Plaster
(d) White Plaster (For pure white material only)
(e) Stucco

Uses of Gauging Plaster—

This material is always used in connection with lime putty finish and is the essential ingredient which provides an initial set and prevents the slow setting lime from shrinking, checking and peeling before the set of lime itself takes place. The failure to use the proper amount of Gauging Plaster is the cause of most failures on lime putty finish jobs.

The type of Gauging used depends on trade practices in each locality. The following types of material are used:

(1) White Gauging—Quick Set
(2) White Gauging—Slow Set
(3) Grey Gauging—Quick Set
(4) Grey Gauging—Slow Set

Moulding Plaster

This is made from selected rock and specially prepared for requirements of its use. This is also sometimes called Plaster of Paris. It is used for plaster moulds, ornamental plaster work of all kinds and can be used as substitute for quick set Gauging Plaster. It is generally made as a pure white plaster but in a few localities Grey Moulding is used for special purposes.

Prepared Trowel Finishes

These plasters are gypsum finish plasters manufactured to avoid the problems involved in use of ordinary lime putty finish. They contain no lime but various ingredients are added to produce exceptionally easy working and spreading qualities. Water only is added on the job. They are also known as

(a) Smooth Trowel Finishes
(b) Gypsum Trowel Finishes

Uses of Prepared Trowel Finishes—

These finishes are available as a substitute for lime putty finish whenever desired. They have replaced lime putty finish in some markets. They have the advantage of perfect bond to base, quick setting and freedom from danger of lime burn in decoration. These finishes can be safely decorated in any manner as soon as dry.

They are available in both grey and white.

Sand Float Finishes

These are also prepared gypsum finish with addition of fine sand. For use over gypsum base coat. They are used in markets where the semi-rough surface of a sand float finish is desired. As name implies these materials are "floated," not trowel finished.

They are furnished in both grey and white.

Keene's Cement

This is an exceptionally dense gypsum finish, fundamentally different from all other types of gypsum plasters. Made at Medicine Lodge, Kansas, by Best Brothers, the original and largest manufacturer of Keene's Cement in the country and now operated as a division of National Gypsum Company.

Keene's Cement is made in several different styles with various setting times and with the grind ranging from coarse to super-fine as covered in detail on page 22.

Uses of Keene's Cement—

Keene's Cement is used wherever extremely dense walls are required, such as imitation tile finishes in bathrooms and kitchens or any place where the walls will be subjected to unusual abuse. Also used as a finish coat instead of lime putty, for castings and running moulds, backing up artificial marble, also for the facing of artificial marble and for numerous ornamental plastering effects.

NATIONAL GYPSUM CO. GYPSUM PLASTERS

APPROXIMATE YARD COVERAGE PER TON ON VARIOUS PLASTERING BASES

Type of plaster	Gypsum lath	Gypsum insulating lath	Painted metal lath	Wood lath	Gypsum tile	Brick and clay tile	Concrete surfaces	Bags type weight, lbs.
Neat*	225-240 Sanded 1-2	225-240 Sanded 1-2	105-135 Sanded 1-2	180-210 Sanded 1-2	235-255 Sanded 1-3	165-200 Sanded 1-3	Use Bond Plaster	Paper 100 lbs.
Sand d	75-80	75-80	35-45	60-70	65-70	45-55	Use Bond Plaster	Paper 100 lbs.
Wood Fibered	115-120 Water only no sand	115-120 Water only no sand	56-65 Water only no sand	90-100 Water only no sand			Use Bond Plaster	Paper 100 lbs.
Bond		90 to 120 sq. yds., depending on smoothness of surface of concrete						Paper 100 lbs.
Gauging Plaster		1600 sq. yds. with 2 tons of hydrated lime						Paper 100 lbs.
Prepared Sand Float Finish		250-275 sq. yds.						Paper 100 lbs.
Prepared Trowel Finish		300-400 sq. yds.						Paper 100 lbs.
Keene's Cement		400-500 sq. yds.						Paper 100 lbs.

*Sanded 1-2 equals 1 part of plaster 2 parts sand by weight.
Sanded 1-3 equals 1 part plaster 3 parts sand by weight.

PLASTER PROBLEMS AND THEIR SOLUTION

Gypsum plasters are a highly sensitive chemical product and therefore subject to changes resulting from use under adverse conditions. A knowledge of the effect of these conditions on gypsum plasters as covered by the following table will insure the satisfactory correction of practically all plaster problems which arise:

SLOW SET: If plaster fails to set in 4 hours with all proper precautions.

REMEDIES: (1) Add amount Gold Bond Accelerator (usually handful to the bag is sufficient) necessary to give desired set. Sprinkle accelerator over dry plaster before mixing.
or (2) Add handful screened dry set plaster droppings same manner as accelerator.
or (3) Add alum or zinc sulphate in proportions two ounces per gallon water. (Portland cement is also a good accelerator.)

QUICK SET: If plaster sets in box or before it can be darbied.

REMEDIES: (1) Check to see if mixing box, tools and sand are clean and clean water used.
(2) Use retarder or ground glue in amount needed for desired set.

SHORT WORKING: If mortar works hard, does not carry sand, drops easily from wall.

REMEDIES: (1) See if material is stored in dry place.
(2) Add fresh plaster bag to bag.
(3) Decrease amount sand and water.

PLASTER TROUBLES AFTER APPLICATION

IF PLASTERED WALL IS:	THE TROUBLE IS:	REMEDY:	TO PREVENT TROUBLE IN FUTURE:
Soft, white, chalky particularly over openings. Hot weather condition.	"Dry Out." Plaster dried before setting.	Spray walls with clean water. Keep wet till set.	Screen openings. Wet lath and floors. Avoid thin coats. If plaster slow set use accelerator.
Damp. Soft. Winter condition.	"Sweat Out." Plaster holds water and "rots."	After plaster is set open doors and windows. Supply heat.	Allow ventilation to hasten drying after plaster is set. Supply artificial heat in cold weather.
Soft, resembling sweat out—rooms have been at freezing temperature.	Walls are frozen.	Throw open building. Let walls freeze dry.	Keep walls from freezing until plaster is dry or at least 24 hours.
Soft, not due slow set or hot weather or retempering plaster.	(1) Too much sand. (2) Too fine sand.	None.	(1) Measure sand accurately. Do not use over 3 parts by weight. (2) Use other sand.
Wood lath. Cracks or bulges horizontal with lath. Straight vertical cracks.	Due swelling poor grade of lath or improperly spaced or failure to wet down. Failure stagger joints.	Remove and replaster.	Use No. 1 lath, white pine, cypress or spruce free from bark, sap, or knots. Space 1/4" to 3/8" apart. Stagger. Wet lath before plastering.
Gypsum lath. Cracks around joints.	Too thin coat.	Apply second coat.	Use proper grounds.
Metal lath. Sags, cracks, does not adhere.	Too light lath, too open spaces, plaster not double fibered. Plaster over sanded.	Reapply.	Correct conditions mentioned.
Brick or tile. Small cracks.	Failure wet before plastering. Too little sand. One coat work.	Float crack or apply more plaster.	(1) Wet tile before plastering. (2) Use 3 parts sand. (3) Two coat work.
Concrete. Poor bond.	Use of improper plaster. Unprepared surface.	Remove loose plaster. Condition wall. Apply bond plaster.	Surface must be rough, clean. Use concrete bonding coat.

GOLD BOND BASE PLASTERS

With Regard to A. S. T. M. Specifications

National Gypsum Company guarantees any Gold Bond Gypsum Plaster product to have about double the strength requirements and to exceed by a wide margin the purity required for any special plaster product in the A. S. T. M. Specifications and also every other detail of these specifications. This also applies to Federal specifications.

GOLD BOND CEMENT PLASTER

Neat Plaster for Base Coats—Fibered or Unfibered

Gold Bond Cement Plaster is "neat," not sanded, the sand being added at the job. Each shipment is prepared especially for the locality to which it is shipped and for the sand used in that locality. Fibered with hair or sisal fiber as ordered.

When mixed with sand it spreads well with a uniform working quality and with satisfactory results on the finished wall. On account of the purity of the gypsum it assures the maximum in sand carrying capacity, bulk and workability.

Note: Cement plaster should never be used neat—i. e., withoout adding sand.

Mixing and Proportions of Sand for Various Bases

After thoroughly mixing with sand, hoe plaster into water and bring to a uniform mix of proper consistency.

Scratch Coat on Gypsum, Wood and Metal Lath

Mix 1 part plaster with 2 parts by weight of dry sand.

On Brick and Gypsum or Clay Tile

Use 1 part plaster to 3 parts by weight of sand.

Brown Coat (Second) for All Plaster Bases

Mix 1 part of plaster to 3 parts of sand.

Application on Various Bases

On Gypsum Lath—Do not wet lath. Apply in 2 coats, scratching well in to fill joints between the lathing units. Brown coat to be darbied lightly and water used sparingly.

On Wood Lath—Soak lath 24 hours before and wet again an hour or two before plastering. Apply in 2 coats using sufficient pressure on scratch coat to obtain good key. Brown coat to be darbied lightly and water used sparingly.

On Metal Lath—Apply in 2 coats. Scratch coat to lightly cover lath and fill mesh. Scratch first coat and allow to set. Then apply brown coat, darby lightly and use water sparingly.

On Brick and Gypsum or Clay Tile—Soak brick or clay tile walls and sprinkle gypsum tile lightly before application of plaster. Apply in 2 coats. Darby brown coat lightly and use water sparingly.

Approximate Covering Capacity and Sanding

Plastering base	Gypsum lath	Wood lath	Metal lath	Brick and clay tile	Gypsum tile
Sq. yds. per ton	225-240 1 plaster 2 sand	180-210 1 plaster 2 sand	105-135 1 plaster 2 sand	165-200 1 plaster 3 of sand	235-255 1 plaster 3 of sand

Full ½ in. grounds should be used for best plaster work.

GOLD BOND SANDED PLASTER

For Base Coats Where Prepared Sanded Plaster Is Desired

Gold Bond Sanded Plaster is the same as cement plaster but is accurately factory mixed and sanded with especially selected and graded sharp sand. It requires only the addition of water and mixing to be ready for use. It is useful for localities where good local sand is difficult to obtain or where accurately mixed material is wanted

Gold Bond Sanded Plaster is also desirable for use during the winter as it eliminates the need for drying sand which is wet and frozen or for trying to secure unfrozen sand.

Gold Bond Sanded Plaster is also useful for remodeling and repair work as it may be mixed inside the building.

Approximate Covering Capacity

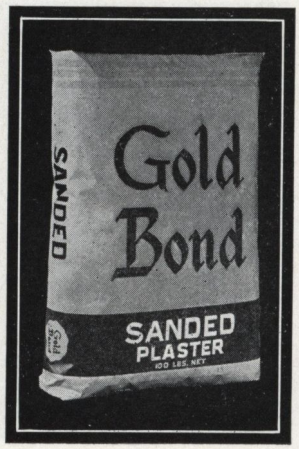
Plastering base	Gypsum lath	Wood lath	Metal lath	Brick and clay tile	Gypsum tile
Sq. yds. per ton	75-80	60-70	35-40	45-55	65-70
		No sanding required—add water only			

Application on Various Bases—Gold Bond Sanded Plasters are applied to the various plastering bases in the same manner as for Cement Plaster (see description above).

Mixing—Add nothing but water, hoeing plaster into water and mixing thoroughly. First mix thin, then add dry material to bring to proper consistency.



At Left:
Gold Bond Cement Plaster Bag



At Right:
Gold Bond Sanded Plaster Bag

GOLD BOND BASE PLASTERS (Continued)

GOLD BOND WOOD FIBERED PLASTER

Used for Base Coats Except on Brick and Gypsum and Clay Tile

Unsanded or "Neat" Wood Fibered Plaster is a gypsum plaster containing finely shredded wood fiber and requires only the addition of water to be ready for use. It does not require sand but in some localities 1 part, by weight, of sand is added.

The wood fibered plaster when used unsanded avoids dangers of over-sanding and works and spreads freely and easily. The plaster is about two-thirds lighter in weight than sanded plaster. The wood fiber acts as a reinforcing and produces a dense, tough, strong and durable base, especially for troweling. It is superior in fire resisting and sound deadening qualities to sanded plasters and will stand up where strains and vibrations are encountered. It saws like wood. It is especially adapted for winter work and alterations as it is easily handled.

Sanded Wood Fibered Plaster—Same as unsanded but is shipped factory mixed with proper amount finely graded sand.

Mixing for Application on Various Bases

Hoe plaster into water and allow to soak for 10 to 20 minutes, then mix to the proper consistency.

Scratch Coat—Use "Neat" or Sanded for wood, gypsum lath and metal lath.

Brown Coat—Use "Neat" or Sanded for wood and gypsum lath and Sanded for metal lath.

Note: Do not use either on Brick and Gypsum or Clay Tile.

Application on Various Bases

On Gypsum Lath—Do not wet lath. Apply in coats scratching well to fill joints between the lathing units and scratch surface. Allow first coat to set and dry; then apply brown coat and broom surface before it sets.

On Wood Lath—Soak lath. Apply in coats, applying scratch coat with sufficient pressure to obtain proper key and scratch surface. Apply brown coat and broom surface before it sets.

On Metal Lath—Apply in two coats, applying scratch coat, of stiffer consistency, to cover lath and fill mesh. Apply brown coat and broom surface before it sets.

On Brick and Gypsum or Clay Tile—

Note: Wood Fibered Plaster is not recommended for use on these bases.

Approximate Covering Capacity

Plastering base	Gypsum lath	Wood lath	Metal lath	Brick and clay tile	Gypsum tile
Sq. yds. per ton	115-120 Unsanded add water only	90-100 Unsanded add water only	55-65 Unsanded add water only	Not recommended on these bases	

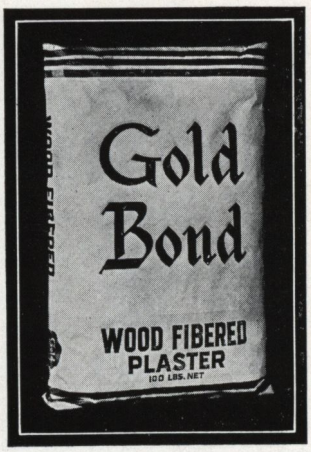
GOLD BOND CONCRETE BONDING PLASTER

For Base Coats on Interior Concrete Surfaces

This plaster is made especially to bond to concrete surfaces, on which ordinary gypsum or lime plasters will not adhere properly. It is used for scratch and brown coats. Only water should be added on the job. Do not use with sand.

All surfaces of concrete must be dry, absolutely clean, free from oil and efflorescence and should be roughened if the surface is troweled smooth.

The plaster should be applied in two thin coats just thick enough to make a smooth wall and not over 1/8 in. total thickness. Any plaster finish may be used over the bonding plaster. The finished surface should not be decorated for a year in order to allow time for any moisture in concrete to work out.



At Left:
Gold Bond Wood Fibered Plaster Bag

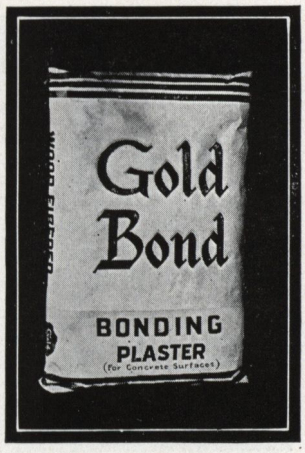
Mixing and Application

Mixing—Add nothing but water and hoe plaster into the water, allowing to soak for 10 to 20 minutes, then mix thoroughly to a smooth creamy consistency.

Application—Apply in 2 coats—First coat shall be scratched on as thin as possible, scratched and allowed to dry. Apply second coat just thick enough to level up inequalities, with total thickness not over 1/8 in. for both coats. Scratch the surface of bond plaster thoroughly to provide mechanical key for finish.

Approximate Covering Capacity

Approximately from 90 to 120 sq. yards per ton, depending on roughness of concrete and thickness applied.



At Right:
Gold Bond Concrete Bonding Plaster Bag

GOLD BOND FINISHING PLASTERS

With Regard to A. S. T. M. Specifications

National Gypsum Company guarantees any Gold Bond Gypsum Plaster product to have about double the strength requirements and to exceed by a wide margin the purity required for any special plaster product in the A. S. T. M. Specifications, also every other detail of specifications. This also applies to Government specifications.

GOLD BOND GAUGING PLASTER

For Gauging Gold Bond Lime Putty Finish

Gauging plaster is a specially selected, ground, calcined gypsum used with lime putty plasters to quicken the set of the lime putty and prevent checking of lime finish. Is uniformly ground to a fineness to insure easy mixing and working qualities. Also known as Plaster of Paris. Supplied in following types:

Quick Set or Slow Set

Gold Bond Super White (White).
Gold Bond Sapphire (Grey).

Directions for Mixing

Use as directed under Gold Bond Finishing Lime.

Covering Capacity

Under normal conditions one ton of Gauging Plaster to two tons of hydrated lime by weight will cover approximately 1600 sq. yds.

GOLD BOND PREPARED TROWEL AND SAND FLOAT FINISHES

For White or Sand Float Gypsum Finishes Over Gypsum Base Coats

These prepared gypsum plasters are for use as finish over gypsum base coats in place of lime putty finish. They make a perfect bond with the gypsum plaster base coats. They have exceptionally easy working and spreading qualities, set quickly and walls may be decorated in any manner as soon as they become dry. There is no danger of lime burns in decorations.

Sand Float Finishes contain clean sharp silica sand which has been screened, graded and dried. This sanded plaster is especially recommended for use in winter when it is difficult to secure the proper sand.

Mixing and Application

Mixing—Hoe plaster into water (adding 2 parts of plaster to 1 part of water by volume) and allow to soak for 10 minutes. Mix thoroughly to produce a smooth creamy consistency and add water until very thin.

Trowel Finish—Base coat must be hard and at least half dry before finish is applied. If suction is too great sprinkle base with water. Apply in three coats, the first coat very thin, well scratched into the surface. Allow to draw for a few minutes then lay on second coat and level off. Apply third coat very thin, filling in all imperfections and allow to draw for a few minutes. Then trowel to smooth finish, applying water sparingly with brush and complete troweling before plaster sets.

Sand Float Finish—Gypsum base coat must be hard and about half dry before finish is applied. Trowel on and finish with a float to true and even surface, using water sparingly from a damp brush and complete before finish sets.

GOLD BOND MOULDING PLASTER

Gold Bond Moulding Plaster (Plaster of Paris) is made for use in ornamental plaster work. It is made from selected gypsum rock of greatest purity and whiteness and undergoes special preparations for the purposes for which it is used. The purity of the gypsum deposits of the company allows the production of moulding plaster of the very finest quality. It makes an especially smooth working plaster of uniform set. It is ground finer than other gypsum plasters and permits a finer surface and greater freedom from pin holes.

On account of its hardness and great strength after setting it is used for plaster moulds and ornamental work of all kinds. The plaster sets with little heat resulting in low expansion and contraction, especially desirable when used in moulds. The low temperature does not affect glue or gelatine moulds. It is used for running mouldings, cornices and ornamental use of a similar type as it can be worked so smoothly and produces a perfect, smooth surface.

Mixing Directions

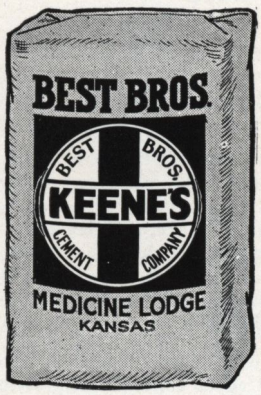
Mix with water only and bring to proper consistency for use.

GOLD BOND PATCHING PLASTER

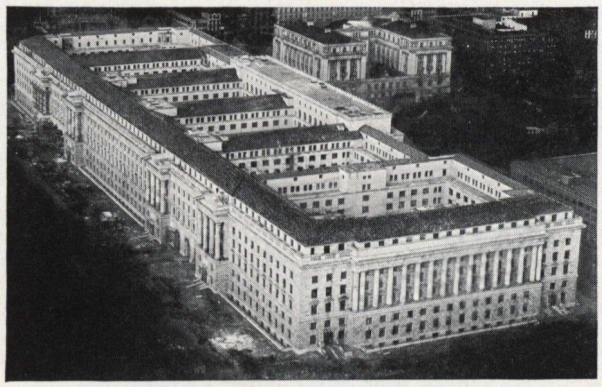
National Gypsum Company with its years of experience in manufacturing plaster has perfected this easier-working patching plaster. Made of highest quality gypsum and requires only the addition of water. Spreads smoothly and hardens to a rock-like finish without danger of shrinkage. Pure white color. Supplied in 2½, 5 and 15 pound cartons.

BEST BROS. KEENE'S CEMENT PRODUCTS

Made of Selected Gypsum Rock of Exceptional Purity. The Toughest, Most Durable and Whitest Finish Coat Obtainable



MADE of purest gypsum rock, BEST BROS.' Keene's Cement is the whitest finish plaster obtainable and produces a wall with extreme durability. Because of its density it excels for wainscots in kitchens and baths and is also used extensively for the finish coat in auditoriums, public buildings and other places where the walls will be subjected to unusually hard wear or abuse. For running moulds and ornamental plastering effects, BEST BROS.' Keene's Cement has been the "old standby" of plasterers for many years because of its unmatched high quality and uniformity.



(above) Department of Commerce, Washington, D. C., Best Bros. Keene's Cement used for 3¾ miles of corridors in this building because of its greater durability.

TYPES AND USES

Best Bros. Keene's "Regular"

Standard grade for ordinary plastering. It is of good color and fairly coarse grind so as to mix readily with lime putty; has a tensile strength of over 600 lbs. per sq. in. in 7 days; an initial set of 2 hours and a final set of 4 hours.

Best Bros. Keene's "Fine"

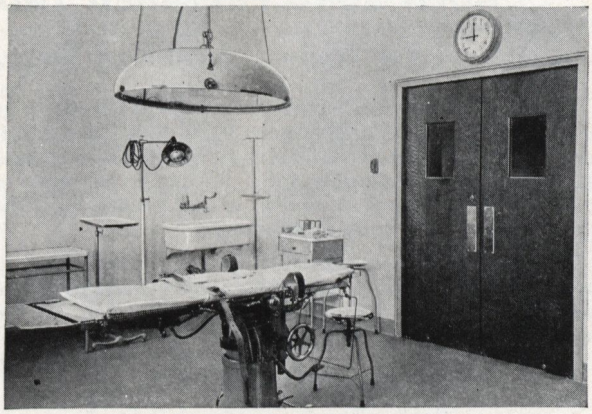
Same tensile strength and setting time as the "Regular" grade but is ground finer and is of uniform purity of color, being made from hand picked rock. Used for backing up artificial marble; for making caen stone; for various other effects in ornamental plastering; and, occasionally, for finish coat.

Best Bros. Keene's "Fast Finish"

Manufactured specifically for a smooth finish coat, and is made to set up more quickly than "Regular" grade when mixed with lime putty. Designed to overcome the long interval of time that has previously been necessary between the application and the final troweling of a Keene's Cement finish. It is ground the same as the "Regular" grade; has a job set of 2 hours; and a tensile strength of over 500 lbs. per sq. in.

Best Bros. Keene's "Quickset"

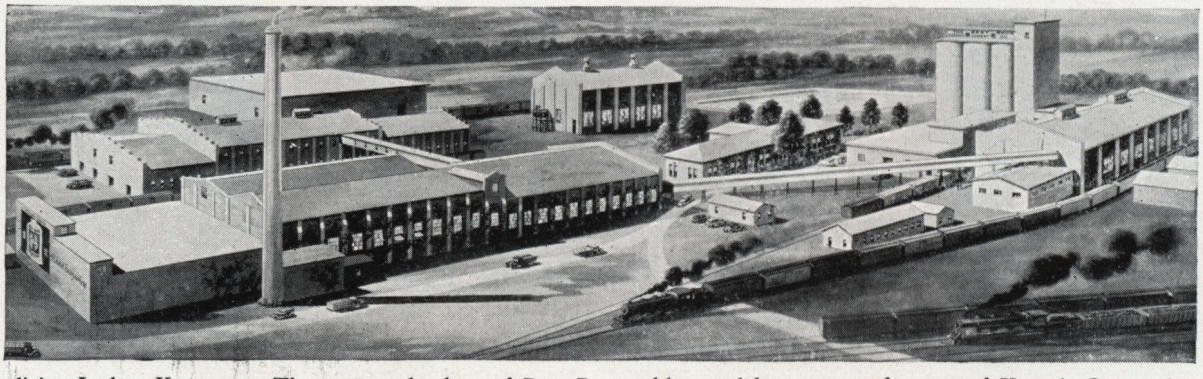
Designed specifically for castings, running mouldings, precast travertine, and similar purposes where the material is used neat and has to set in the shortest time. It is finely ground; of pure white color; has an initial set of 20 minutes and a final set of 35 to 40 minutes. Tensile strength, 600 lbs. per sq. in.



(below) Hospital rooms must be able to "take it." Best Bros. Keene's Cement is invariably the choice of architects and contractors because of its proven durability for the past 50 years.

Best Bros. Keene's "Superfine"

This grade is used only for the facing of artificial marble. It is very slow setting, having an initial set of 4 hours and a final set of 8 hours. It is pure white and very finely ground.



Medicine Lodge, Kansas . . . The mammoth plant of Best Bros., oldest and largest manufacturer of Keene's Cement in the country. Now operated as a division of National Gypsum Company.

GOLD BOND FINISH LIME

Gold Bond Lime from Famous Ohio Lime Country

The very finest lime deposit in the world is that in the northwestern Ohio dolomite lime fields. This is located a few miles south of Toledo and by far the largest quantity of finish lime produced in the country comes from producers located within an area of a radius of about five miles.

Gold Bond Lime is produced in this area at our plant at Luckey, Ohio, and the purity of the lime ranks with the finest produced in this high quality lime producing section.

The Quality of Dolomite Limestone

The chemically pure dolomite limestone contains 45.5% magnesium carbonate and 54.5% calcium carbonate. A. S. T. M. specifications require a 95% minimum oxides of the two combined. The Gold Bond deposits average between 98% and 99% containing 55.56% Calcium Carbonate and 43.41% Magnesium Carbonate.

It is the magnesium carbonate, when properly burned which gives the plasticity and easy slip or working qualities of a building lime. It is due to the quality of plasticity that the dolomite lime is so favored by the trade. Limes of high calcium content are not as easily worked as the Ohio dolomite lime.

Automatic and Machine Controlled Burning of Lime

One of the important steps in the production of good lime is in the proper burning of the magnesium carbonate. As the calcium and magnesium carbonate require widely different temperature to change them to oxides by burning, it requires very careful regulation of heat. The National Gypsum Company has patented and installed apparatus which definitely controls the burning automatically as against depending on the skill of a fireman in control of his fires, so that overburning is a practical impossibility. Overburning makes the lime tough and hard working without "slip" and will not hold its water against the suction of the wall.

Hydration Scientifically Controlled

The process of hydration is also absolutely and automatically controlled by the equipment of this company. Lime as it comes from the kiln exists as calcium and magnesium oxides. A definite percentage of water is added which combines chemically with the calcium oxide but *not* with the magnesium oxide. The lime is then ground and sacked.

The Reason for Soaking Lime Overnight

The small amount of water used in hydration does not combine with the magnesium oxide. When soaked overnight, the magnesium oxide slowly reacts and forms a "jelly" which produces the slip and easy working qualities of the Ohio dolomite lime. It will therefore be readily seen that the more perfect the hydration of the magnesium the greater the plasticity of the lime.

Plasticity the Test of Quality of Gold Bond Lime

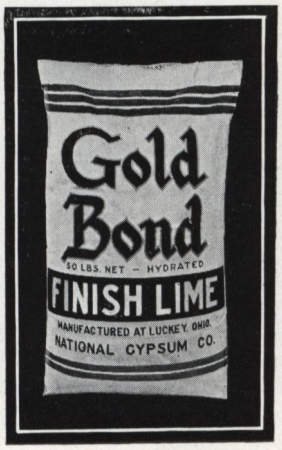
One of the most important tests of lime is that of its plasticity. In the Federal Standard Stock Catalogue, SS1L-351, Section IV, Part 5, E-6, it requires that finishing hydrated lime shall have a plasticity figure of not less than 200. The minimum value which our plant specifications allow to be shipped as finish lime is 300.

Mixing Gold Bond Finish Lime—Fill water tight box about two-thirds full of clean water. The dry lime should then be sifted gradually into the water until fully soaked. Enough excess water to provide 1 to 2 in. of water over the lime should be supplied. Soak overnight. In application, mix 3 parts of lime putty by 1 part of dry gauging plaster by volume. Mix thoroughly.

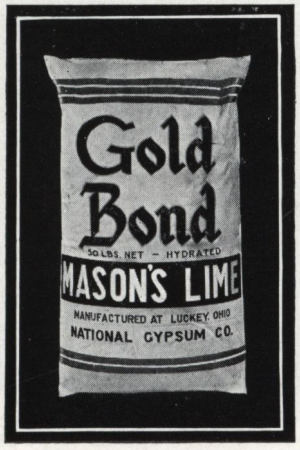
Covering Capacity—Under average conditions, the proportions specified should cover approximately 500 to 700 sq. yds. per ton of lime. Shipped in 50 lb. paper bags.

GOLD BOND MASON'S LIME

A hydrated lime for use with lime cement and sand, or lime and sand mortars, or for concrete construction. Used by mason contractors wherever a good easy working lime, which will bulk well in putty is required. Shipped in 50 lb. paper bags.



Gold Bond Finish Lime Bag.



Gold Bond Mason's Lime Bag.

GOLD BOND COLOR TEXTURE

A Plastic Texture Finish for Walls and Ceilings That Is Supplied Already Tinted . . . Six Pastel Shades and White . . . For Use Over Practically Any Surface . . . The Ideal Decoration for Gypsum Wallboard

Beautiful Textured Walls at Low Cost

The artistic richness of textured interiors often gives the impression that they are expensive. Instead, the cost is invariably even less than wallpaper when genuine Gold Bond Color Texture is used, for this reason: In new construction, Color Texture is applied directly over the base plaster, eliminating the lime putty or white finish coat. In addition, the cost of wallpaper or other decoration is also saved.

Another important item—textured walls are permanent whereas papered rooms have to be done over every few years. For actual beauty, there is no comparison between textured rooms with their interesting designs and wallpaper with its monotonous patterns repeated over and over. The most expensive wallpapers are often mere imitations of texture designs.



Greater Coverage with Color Texture

Two important advantages contribute to make Gold Bond Color Texture the most popular texturing material and incidentally, the most economical. First, it comes already colored and requires no further decoration. Second, it is a casein base product with outstanding texturing qualities and dries to a hard, durable finish. Coverage is double that of many textures because only a thin coating is required for even the most elaborate texture designs.

Easy Application

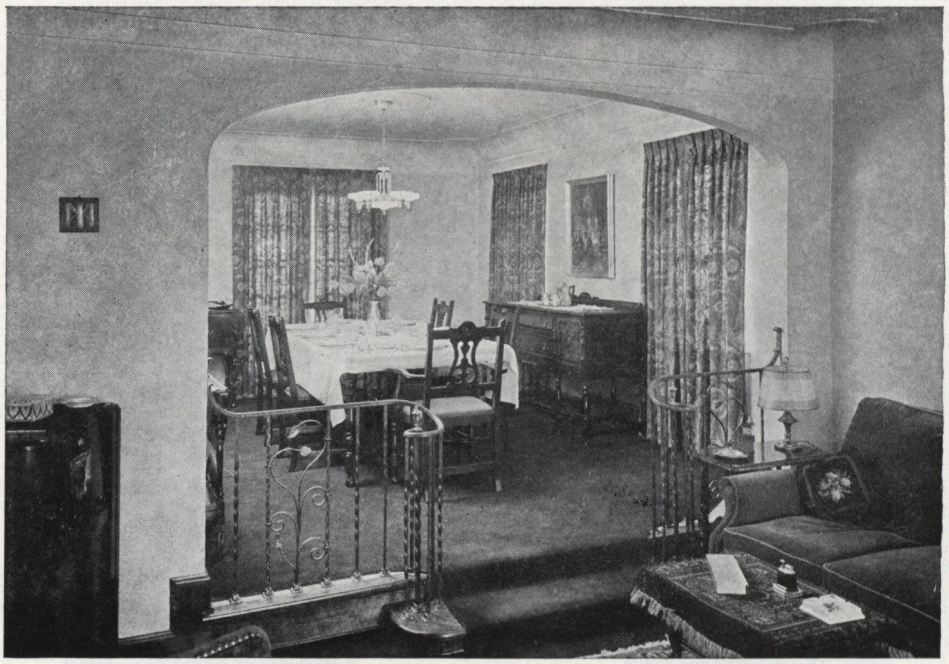
Gold Bond Color Texture is simply mixed with water; applied with paint brush or trowel in a thin coat—$\frac{1}{16}$ to $\frac{3}{32}$ in. thick; then textured with stipple brush, rubber sponge, whisk broom or crumpled paper. A direction sheet is enclosed in each carton giving specific instructions for application over practically every type of surface.

Six Colors

Color Texture comes in Ivory, Light Cream, Light Buff, Light Green, Pink, Light Blue and White. For special color schemes, White Color Texture is used and decorated to suit with Gold Bond Casein Paint (see page 26) . . . Color Texture is supplied in 10 and 25 lb. cartons.

Easily Cleaned

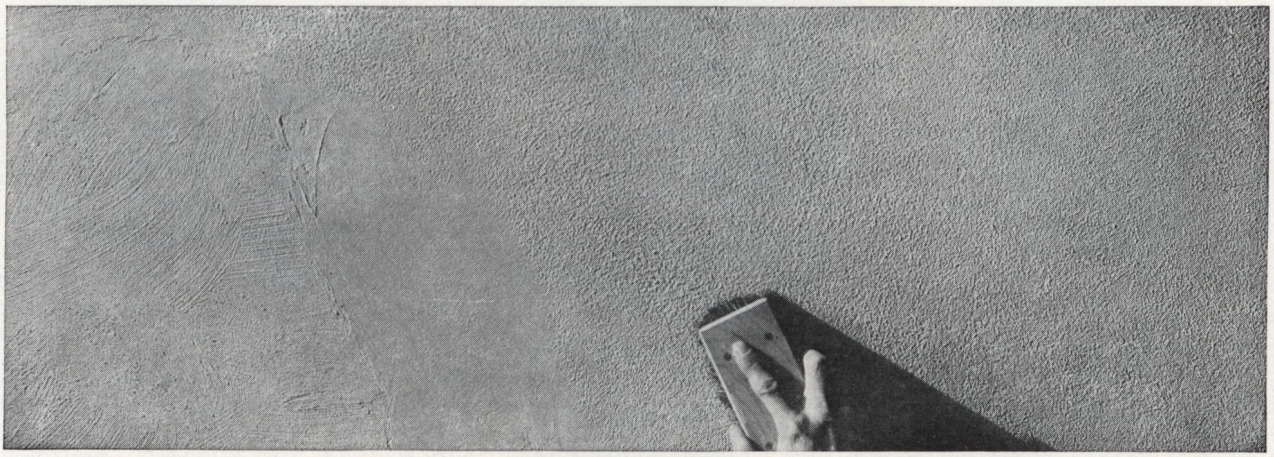
Color Texture interiors can be kept clean and fresh-looking by going over the surface lightly with a damp cloth. . . . Caution! Not all texturing materials can be cleaned this way. Color Texture can because of its casein base.



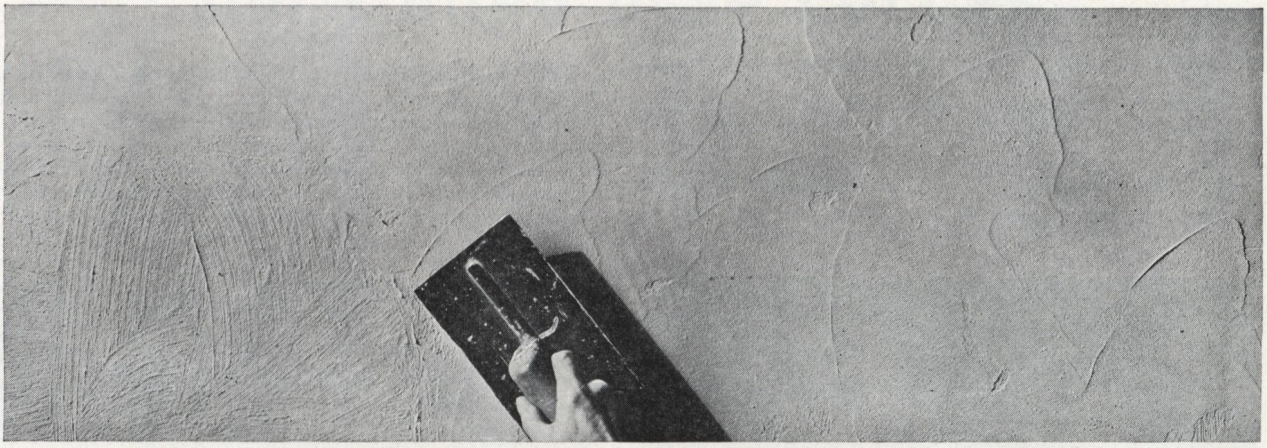
Charming textured interiors in light tints are always warm and inviting. In complete harmony with any type of architecture; any style of furnishings.

Typical Designs Produced With Gold Bond Color Texture

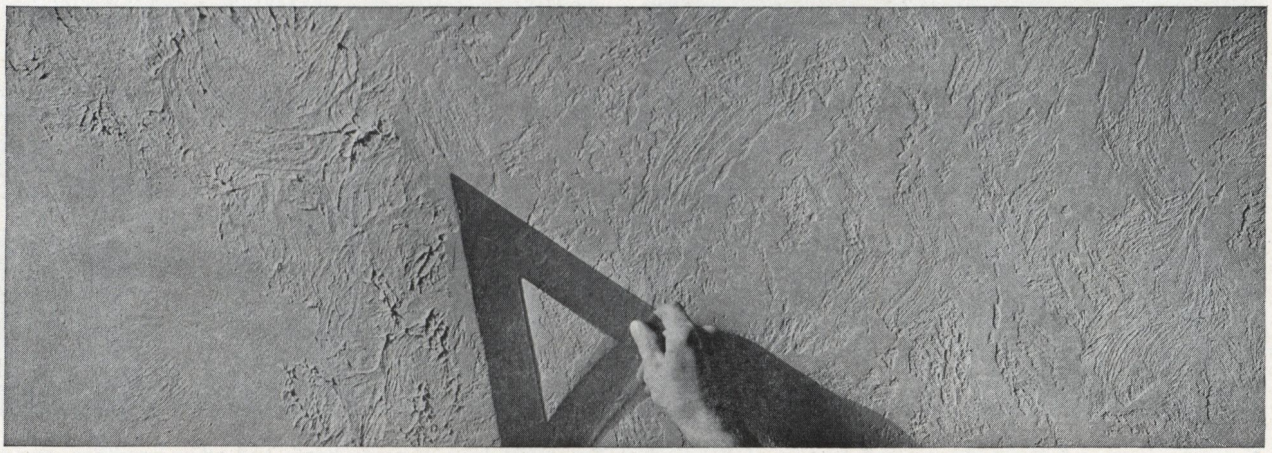
The Progressive Steps to Secure the Finish Are Shown from Left to Right



No. 1 Fine Stipple
Gives the effect of a sand finish. Apply thin coat of Color Texture with trowel or paint brush. Smooth to uniform thickness with trowel. Texture with a fine stipple brush, cleaning brush occasionally to insure uniform texture. Surface may be sand papered if desired to remove any sharp points.



No. 2 English Trowel Finish
A light trowel finish showing marks of trowel. Apply thin coat with trowel or paint brush. Then trowel surface lightly, using back edge of trowel in a curving upward stroke to secure this effect. If stronger texture is desired apply Color Texture thicker and use more pressure when drawing the trowel.



No. 3 An Interesting Texture
This has effect of considerable movement. Apply thin coat of Color Texture with trowel or paint brush. Then add heavier texture with rubber sponge, using face of sponge in a slightly swirling up and down motion. Drag triangle lightly over surface to create high-lights.

NATIONAL GYPSUM COMPANY

GOLD BOND CASEIN PASTE PAINT

A Full Line of Quality Interior Paints that Require Only the Addition of Water as a Thinner . . . Easier to Apply . . . High Light Reflection Without Glare . . . Pastel Tints and Deep Colors

Gold Bond Casein Paint brings new color and beauty to modern interiors at a real saving in time and money. Every day, more decorators are swinging over to this remarkable interior paint which offers all these advantages:

Lime-proof Colors
Won't "yellow" with age
Takes water as a thinner
Dries in an hour
No turpentine odor
Better hiding power
High light reflection
Use with brush or sprayer
Non-inflammable
Costs less



For Jobs in Every Price Range

Quality alone has prompted the use of Gold Bond Casein Paint in the finest homes in the land; theatres, hotels and public buildings. Yet, the surprisingly low price permits its use for all kinds of interior painting jobs including factories, lofts, cheap apartments, public garages.

Important! Because water is used as a thinner, do not confuse Gold Bond Casein Paint with calcimines or "cold-water paints."

One Hour Drying . . . No Turpentine Odor

Restaurants, bakeries and food stores of all kinds used to dread painting because the strong turpentine odor simply "killed" business. Now they can decorate with Gold Bond without fear of driving away customers because there is no turpentine after-smell. . . . Hotel rooms can be repainted in the morning and occupied the same night.

High Light Reflection Without Glare

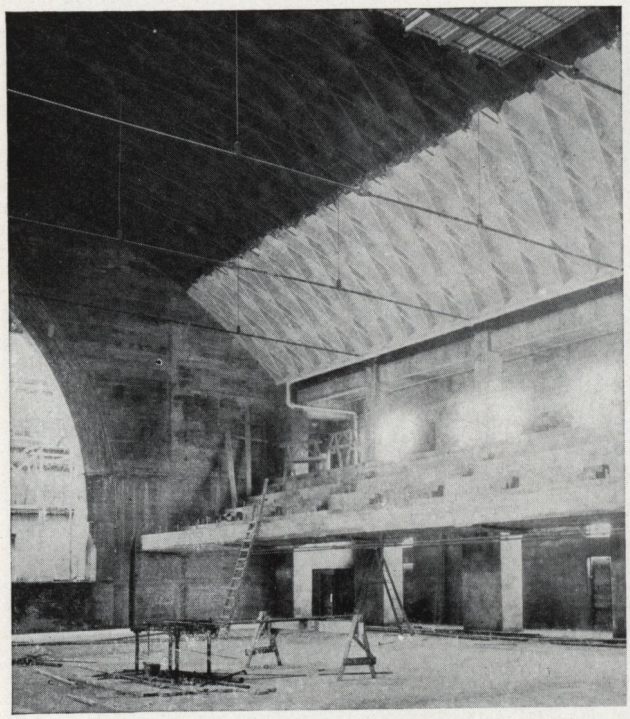
The high light reflection of Gold Bond Casein Paint is of utmost importance in offices, stores and factories, where better lighting means greater efficiency. White Gold Bond Casein Paint reflects well over 90% of the light striking it and the colors rate correspondingly high. Lighting bills are cut as much as 30%.

Meets Government Specifications

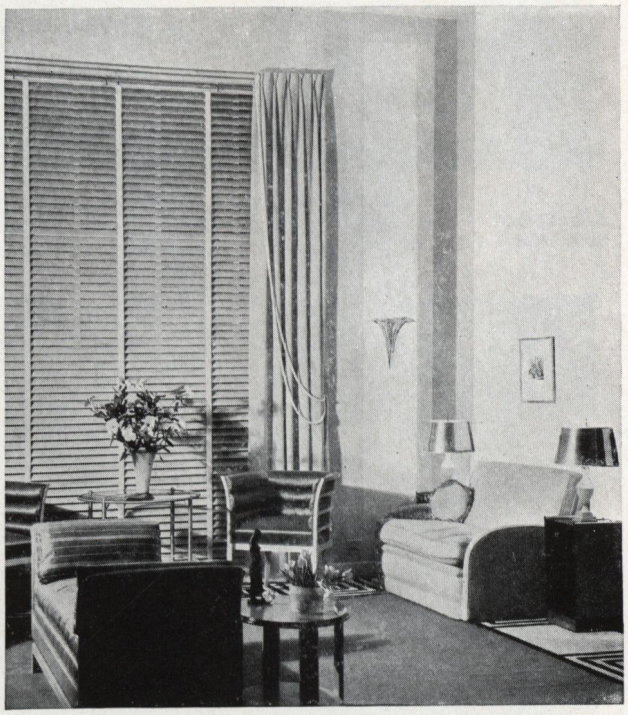
Gold Bond Casein Paint meets Government specifications TT-P-23 Type 2.

Mixing

Use a clean, rustless (preferably new) galvanized pail or tub. Avoid wood containers. Add water to the paste in small portions with thorough stirring after each addition until the desired consistency is obtained. Under average conditions, one gallon of Gold Bond Casein Paint takes two quarts of water. In cold weather or over extremely porous bases, more water may be required. Much time can be saved in applying by using a wide brush.



Note the contrast between the painted portion of this auditorium ceiling and the barn-like appearance of the section still to be done. . . . Doesn't require much imagination to figure what the saving in lighting cost will be.



Superintendents of many hotels and office buildings use Gold Bond exclusively to keep rooms looking smart and inviting. . . . They report, "It's cheaper than washing walls and much quicker."







Nine Pastel Colors and White

Gold Bond Casein Paint is made in White, Old Ivory, New Cream, Buff, Rich Tan, Sky Blue, Pearl Grey, Old Rose, Deep Orchid, Green. Supplied in quart and gallon cans, also in 5-gal. and 30-gal. drums.

Tinting

For special colors, use White Gold Bond Casein Paint and tint with Gold Bond Deep Colors. The latter colors are concentrated and made especially for tinting purposes (described below).

GOLD BOND DEEP COLORS

Concentrated Casein Colors for Tinting White Gold Bond Casein Paint . . . Also Used Full Strength for Deep Color Combinations

Gold Bond Deep Colors are concentrated casein paints in paste form. Made of pure color pigment, ground in casein and supplied in eleven brilliant colors, also black and white. They are used for three distinct purposes: as tinting colors for White Gold Bond Casein Paint; as fine interior paints by simply adding water as a thinner; as artists' colors for showcards, advertising displays and window backgrounds . . . supplied in half pint glass jars, also quart and gallon cans.

Eleven Colors, Black and White

Bright Red, Orange, Yellow, Emerald, Blue, Violet, Indian Red, Ochre, Burnt Sienna, Raw Umber, Burnt Umber, Black, White.

GOLD BOND PIGMENTED PRIMER

An Oil-Base Primer for Use Under Gold Bond Casein Paint, Oil Paints, Calcimines and Textures

Surfaces with excessive suction or uneven absorption should always be given a coat of Gold Bond Pigmented Primer before painting. It "kills" suction and provides a smooth, even base for the paint. Saves the danger of a streaked or spotty job and makes the paint go farther as it actually serves as a first coat. Supplied in quarts, gallons, and 5-gal. cans.

GOLD BOND LIME PROOF MORTAR COLORS

The Gold Bond line comprises a full assortment of highest grade, non-fading, Lime Proof Colors used for tinting Gold Bond (white) Color Texture, Craftex, stucco, mortar and other water mixed materials.

As all Gold Bond Lime Proof Colors are full strength, only small quantities are required for the average job. Accordingly, they are supplied in small, air-tight containers in the following colors:

Red (1½ lbs.) Black (1¾ lbs.) Yellow (¾ lb.)
Blue (1 lb.) Raw Sienna (1¼ lbs.)
Green (1¾ lbs.) Burnt Sienna (1¼ lbs.)
Raw Umber (1 lb.) Burnt Umber (1¼ lbs.)

Packed 24 cans to the case.



Note: All containers are the same size. The difference in weights is because of the varying densities of the colors.

Mixing

Mix the dry color with a little water and stir thoroughly to form a thin paste. Strain this mixture through a fine mesh screen to remove lumps. Then add to the wet mortar, texture, or other material to be colored.

Important! When adding color to the wet mix, keep in mind that the tinted material when dry will be lighter in color.

MASTER SPECIFICATIONS FOR INTERIOR LATHING AND PLASTERING

GENERAL NOTES

Uses of Master Specifications

It is intended that the following specifications will cover practically all conditions which are usually met with in ordinary construction. Only the paragraphs applying to the particular type of job should be selected and used by the architect. Special lathing bases are not included and if these are used the method of application and use of plaster should follow the recommendations of the manufacturer.

Consulting Service on Lathing and Plastering

The National Gypsum Company has over two hundred representatives located throughout its territory who will be glad to consult with architects and lathing and plastering contractors on any lathing or plastering problems which may arise. This is in addition to the technical laboratory and research department located at the Buffalo Office which may be called upon at any time for technical information.

New and Old Work

The following specifications are written only for new work. For alteration work the clauses will have to be altered to cover such work especially in regard to where old and new work join.

SECTION 1

LATHING AND PLASTERING SPECIFICATIONS

Note: (a) Acoustical Plaster—See File Index for specifications on Gold Bond Trowel Finish Macoustic.

(b) If trade practice requires separate specifications for lathing and for plastering, the specification should be written accordingly.

1. General Conditions

The General Conditions of the Contract of the American Institute of Architects (current edition) shall form a part of this specification. (If the A.I.A. Standard Form is not used then refer to the one used.)

2. Scope

2–1. This contractor shall furnish all materials, labor, scaffolding and staging which will be required to satisfactorily complete the lathing and plastering work to be executed as hereinafter described or indicated on the contract drawings or schedules.

3. Extent of Work—Furring, Lathing and Plastering

3–1. All Metal Furred or Suspended Ceilings

Note: Wood furring or hung ceilings should be specified under carpentry.

3–2. All metal wall furring and miscellaneous metal furring

3–3. All metal stud partitions

3–4. All lathing

3–5. All interior plastering including Keene's Cement as follows:

Note: Here describe exceptions and amplifications in regard to lathing and plastering or refer to schedule of finishes and drawings.

- **a.** Note where plaster is to be omitted.
- **b.** Note where one or two coat plaster is required.
- **c.** Note where white finish is omitted.
- **d.** Note ceiling or beams, cornices, etc., to be furred (Type furring)
- **e.** Note walls to be furred (Type furring)
- **f.** Note if lath or base and scratch coats back of tile work, marble or slate are to be included or omitted from this contract.

4. Relations with Other Trades

4–1. Temporary Enclosures — Temporary cloth enclosures over all window and other exterior openings throughout the portions of the building to be plastered shall be provided and maintained by the carpenter during application and drying of plaster.

4–2. Temporary Heat, Light and Water—Shall be supplied by others.

Note: Plastering Contractor or General Contractor may be required to supply salamanders, fuel, heat and maintenance without fire hazard before heating plant is installed, depending on contract agreements. After heating system is installed heat may be supplied by heating system through the General Contractor or Owner.

4–3. Grounds and Furring—All necessary wood grounds for furring and lathing shall be installed by others.

4–4. Inspection of Grounds and Plastering Bases—All grounds and plastering bases shall be inspected by this contractor from time to time and before commencing his work and he shall report to the Architect and General Contractor any defects in such work which may in his opinion affect satisfactory finish, accuracy and stability of the work under his contract.

4–5. Failure to report such defects requiring correction or replacement before commencing his work shall be construed as acceptance of such work by this contractor and he shall not be relieved of responsibility and obligation under his guaranty.

5. Protection of Work and Building

5–1. All finished work, such as woodwork and glass, shall be adequately protected by Contractor from damage and plaster droppings and he shall make good such damage at his own expense and without cost to the owner.

5–2. Furnish, install and maintain waterproof protection at source of water, under all mixing boxes and gauging barrels.

5–3. Any spill or drip of any kind shall be taken up at once and any sand, sawdust or protection for floor if removed shall be replaced with new material.

5–4. This Contractor shall be responsible for all damage occasioned by the mixing, handling and storing of mortar and materials or through his failure to provide necessary protection.

6. Patching

6–1. All plaster work which is damaged by this Contractor shall be made good by him at his own expense.

6–2. After the erection of finish by other trades, this Contractor shall patch all plaster which is damaged by other mechanics but the cost shall be paid for by the Contractor who caused the damage.

6–3. This Contractor shall cut out, when required, any defect in his work and replaster and leave in perfect condition.

7. Preparation of Surfaces

7–1. This Contractor shall clean the surface to which or against which plaster is to be applied, removing all mortar droppings, etc., as may be necessary, to allow plaster to adhere to same.

7–2. Concrete surfaces and combination tile and concrete surfaces which are too smooth to receive plaster shall be sufficiently roughened by hacking to secure adequate bond.

Note: (Hacking will be done by others.) Concrete forms should be made of rough boards and be free from oil.

7–3. Concrete surfaces shall be dry and brushed free from dust, soot, grease and oil. (Burn off oil or grease with torch.) Any low places in masonry walls shall be filled out and any unevenness shall be straightened with unfibered plaster ahead of base coat.

7–4. Efflorescence shall be removed with a wire brush and washed with muriatic acid and water, one (1) to five (5) solution. Remove acid by thorough washing with clean water.

7–5. Wood Lath shall be wetted down as specified under Wood Lath, Sec. 5, Par. 1-1-1.

7–6. Gypsum lath and fiber insulating lath shall not be wetted down at any time.

7–7. Where necessary for suction, wet brick, concrete and clay tile surfaces before plastering.

8. Wood Grounds

All wood grounds shall be provided and installed by the Carpenter and shall be of such thickness and so set to provide for ½ in. thick plaster over all types of laths and gypsum tile and ⅝ in. thick plaster over all brick, clay tile and other masonry.

Wood Lath	¾ in. grounds
Gypsum Lath ⅜ in. thick	⅞ in. grounds
Insulating Board ½ in. thick	1 in. grounds
Metal Lath—Expanded, Sheet and Wire	¾ in. grounds
Gypsum Tile	½ in. grounds
Brick and Clay Tile	⅝ in. grounds

Note: Thickness of grounds includes thickness of lath.

9. Sample Finishes

Where special textured finishes are required, this Contractor before proceeding with the work shall prepare and erect, where directed by the Architect, sample panel of each finish required, not less than 3 ft. square. These samples shall be made to the satisfaction of the Architect. After approval by the Architect, the finished work shall equal the samples in all respects.

10. Workmanship

All work shall be executed by skilled workmen in such a manner as to fulfill the requirements of the drawings and specifications.

11. Cleaning

11–1. After completion of his work, this Contractor shall remove from the building all scaffolding and tools of every sort used by him, taking care not to damage work of the other trades.

11–2. All plaster rubbish, plaster droppings, etc., shall be removed by this Contractor and the building left broom clean.

11–3. (This Contractor shall remove all plaster from glass and other finish and leave in first class condition.)

11–4. (The removal of debris and cleaning required, resulting from the work of the Contractor, shall be done by others.)

12. Guarantee

12–1. This Contractor shall furnish a written guarantee as a part of this contract, warranting all work and materials under this contract against defects for a period of (one year) (specifying time) from the completion and acceptance of the work as shown by date of final payment and he binds himself to repair and replace any defect which may develop within that period, without additional payment beyond the amount of the contract, when ordered to do so by the Owner or the Architect.

12–2. (This shall also include the cost or repairs or replacement of any material, decoration or other finish damaged by the defects.)

SECTION 2

FURRING AND SUSPENDED CEILINGS

(Specifications for Gold Bond "Clip-on" Systems—Suspended Ceilings and 2-in. Solid Partitions are given in detail in separate books sent gratis upon request.)

1. Wood Furring and Suspended Ceilings

Note: Wood furring and suspended ceilings which are to be plastered should be included under Carpentry.

2. Masonry Furring

Masonry furring such as hollow blocks of tile, etc., should be included under Masonry.

3. Materials

3–1. Metal Furring—Shall be Gold Bond Cold Rolled Channels. (See page (10).)

3–2. Metal Partition Studs—Shall be Gold Bond Cold Rolled Channels of sizes specified.

4. Metal Furred Suspended Ceilings

4–1. Location—Ceilings shall be furred or suspended with metal furring where so indicated on plans or on schedules. Where finished surfaces of plastered ceilings are six (6) in. or more below the soffit of floor construction, they shall be considered as suspended ceilings.

4–2. Hangers—Shall be placed not to exceed 4 ft. center to center in either direction. The minimum size for hangers shall be No. 8 galvanized wire, 1 x $\frac{3}{16}$ in. flats or $\frac{7}{32}$ in. round mild steel rods.

The upper ends of hangers if wire, rods or flats, shall be of sufficient length to wrap around beams or provide a suitable anchorage in concrete or tile. Where steel beams or purlins are not more than 4 ft. center to center, hangers may be attached directly to them. When hangers are hung from concrete beams or arches, the hangers shall be placed before concrete is poured. When ceilings are hung from terra cotta floors, hangers may be installed at tile joints during erection, or may be installed after tile is in place, holes bored clear

NATIONAL GYPSUM COMPANY

through tile and secured on upper side by steel rod or toggle bolt.

4–3. Runner Channels—Shall be placed not to exceed 4 ft. on centers, and shall be not less than 1½ in. cold or hot rolled channels weighing not less than 442 lbs. per thousand lineal feet. Lower end of wire hangers shall be secured to runner channels by three twists around same; lower end of rod hangers shall be secured to runner channels by two twists, or by wiring; lower end of flat steel hangers shall have holes punched at the proper distance to which the runner channels shall be bolted with not less than ⅜ in. diameter bolts.

Runner channels shall conform to the contour of the ceiling.

4–4. Furring Channels—Shall be not less than ¾-in. channels with a minimum weight of 276 lbs. per thousand lineal feet; they shall be erected at right angles to the runner channels of No. 16 galvanized annealed wire at each crossing, or by No. 9 wire hairpin clips.

Furring channels shall be spaced as follows:

Not over 12 in. apart for 3.0-lb. flat expanded metal lath is used, or over 16 in. apart for 3.4-lb. flat expanded metal lath; not over 16 in. apart for 3.0-lb. flat rib expanded metal lath; not over 19½ in. apart for 3-lb. ⅜-in. rib expanded metal lath; and not over 24 in. where 3.4-lb. ⅜-in. rib expanded metal lath is used.

4–5. Metal Lath—Shall weigh not less than 3.00 lbs. for ceiling and 2.50 lbs. per sq. yd. for side walls, provided, however, that minimum weight shall be governed by spacing of furring channels as specified in the preceding paragraph.

The metal lath shall be wired to the furring channels (the long dimension of the sheet being across the channels) by No. 18 gauge galvanized annealed wire every 6 in. along the furring channels; there shall be one tie on side laps half way between channels. Lap sheets at sides and ends not less than 1 in.

Where ceilings, cornices or other features, formed with metal lath, finish against masonry walls, partitions or arch soffits, the lath shall extend onto masonry surface at least three (3) in.

4–6. Brackets for cornices, beams, etc., shall be built up of 1-in. steel members spaced same as for runner channels and shall be securely fastened to masonry or other structure supports. Cross fur and lath same as for ceilings.

5. Metal Stud Partitions

5–1. Solid Partitions—

(a) Metal Studs for solid partitions shall be not less than ¾-in. cold or hot rolled channels weighing not less than 276 lbs. per thousand lineal feet, and spacing of studs shall conform with weight of lath as in paragraph (a) of these specifications.

(b) Studs shall be secured in position by inserting ends in holes punched ¾ in. in top of concrete or other masonry floors or in soffits of masonry ceilings, or by attaching to stud shoes, or by placing ends in holes drilled in wood floor bucks anchored to masonry floors at 4-ft. intervals; on floors by wire-tying to nails driven 1 in. into floors and projecting at least 1 in. above. Where metal lath ceilings are used, a small hole shall be made in the ceiling lath and the end of channel allowed to project through it and be wired to a channel attached to the ceiling lath.

(c) Splicing of studs shall be made by lapping channels not less than 8 in. with flanges interlocked and tied.

(d) Erection of metal lath, for solid lath and metal stud partitions, shall be the same as that given in Par. (1) excepting that metal lath is applied only on one side of channel studs and tied instead of nailed or stapled.

(e) Note: Solid partitions over 6 ft. high shall be temporarily braced horizontally on the channel side at intervals not exceeding 6 ft. vertically before applying plaster. Such bracing shall not be removed until scratch coat on the lath side of the partition has set.

(f) In every case one channel shall be set next to wood buck at each side of openings and double-wired securely to 8d nails driven on each side of channel in pairs into buck at 2-ft. intervals. Bottom of door buck shall be securely spiked to wood plug in floor, or attached by metal anchors.

5–2. Hollow Metal Lath Partitions—Use Specifications (5-1) but call for wide single channel, or a double row of ¾-in. channels with separators every 2 ft. vertically, and metal on both faces of partition.

6. Metal Wall Furring

6–1. Where wall furring is indicated on plans or in schedule for walls, beams, girders and other vertical surfaces, it shall consist of ¾-in. vertical channels spaced not more than (specify spacing) (12-in.) on center and shall extend from floor to ceiling arch and be firmly secured top and bottom. Intermediate braces shall be provided as specified for metal stud partitions. Flanges shall face masonry and shall be secured with special hook nails or other device best suited to the masonry or mortar joints.

6–2. Pipe and Ducts—Pipe and ducts required to be enclosed shall be furred as specified for wall furring. Where required to support plumbing fixtures, additional horizontal members of 1½ x ⅜ in. flats shall be wired to vertical members at proper heights to support fixtures.

6–3. Pipe Chases—Over 12 in. wide shall be furred in same manner as wall furring with metal lath extending at least 3 in. each side of opening.

6–4. Heads and Jambs—Fur and lath heads and jambs of windows and doors, when specified or indicated to be plastered, in same manner as for wall furring.

6–5. Corner Beads—Corner beads shall be installed on all exterior angles in plastered rooms or spaces to run from floor to metal corner bead or to spring line of arches where arch heads are used and shall be of type and gauge as specified under materials.

6–6. Metal Grounds—Shall consist of heavily galvanized steel and shall be set true to plane of finished wall surface and shall be securely fastened to the masonry, furring or other support.

6–7. Miscellaneous Furring—(List here other miscellaneous furring required as for stair soffits and any special features requiring metal furring and lathing.)

6–8. No furring shall be placed until all pipes, conduits, etc., have been permanently placed.

6–9. General—All furring and lathing, for all vertical or horizontal surfaces for walls, cornices, beams, arches, carved work, etc., shall be level, plumb true and rigid and accurately formed so that all surfaces to receive plastering shall be generally one (1) inch back of finished surface.

SECTION 3

LATHING AND PLASTERING ACCESSORIES

1. Materials

1–1. Wood Lath—Shall be No. 1 Grade, or better, free from knots, sap and bark, approximately ⅜ in. thick, 1½ in. wide and either 32 in. or 48 in. long.

1–2. Gypsum Lath—Shall be Gold Bond Gypsum Lath ⅜ in. thick (or ½ in. thick)—16x48 in. (or 16x32 in. or 16x36 in.).

1–3. Metal Lath—Shall be Gold Bond Metal Lath, National Gypsum Co. (specify type, finish and weight for spacings on both horizontal and vertical installations). See pages 17 and 18 for metal lath.

Recommendations of Associated Metal Lath Manufacturers, Inc., follow:

1–4. Minimum Weight of Metal Lath—

(a) *Expanded Metal Lath for Interior Work—*

For vertical position, partitions, etc., attached to metal supports 12 and 13½ in. on center, lath shall weigh a minimum of 2.5 and 3.0 lb., respectively, except for solid partitions where 2.2 lath may be used on 12-in. spacing; and 3.4 lath on 16-in. spacing. For nailed-on partitions, maximum spacing shall be 16 in. for all flat laths, minimum weight to be 2.5 lbs.

For tied-on ceilings attached to metal supports, maximum spacing shall be 12 and 13½ in. for 3.00 and 3.4 lb. flat lath; for nailed-on ceilings, maximum spacing shall be 16-in. for these laths.

(b) *Flat Rib Lath—*

For Nailed or Tied-on Partitions and Furring:
For supports spaced not to exceed 16 in. on centers.....2.75 lb.
For supports spaced not to exceed 19 in. on centers.....3.0 lb.

For Nailed or Tied-on Ceilings:
For supports spaced not to exceed 12 in. on centers.....*2.75 lb.
For supports spaced not to exceed 16 in. on centers.....3.0 lb.
For supports spaced not to exceed 19 in. on centers.....3.4 lb.

*For nailed-on ceilings, this lath may be used 16 in. on centers.

(c) *⅜-in. Rib Lath—*

For Nailed or Tied-on Partitions and Furring:
For supports spaced not to exceed 19 in. on centers.....2.5 lb.
For supports spaced not to exceed 24 in. on centers.....3.0 lb.
For supports spaced not to exceed 31½ in. on centers.....4.0 lb.

For Nailed or Tied-on Ceilings:
For supports spaced not to exceed 19 in. on centers.....2.75 lb.
For supports spaced not to exceed 24 in. on centers.....3.0 lb.
For supports spaced not to exceed 31½ in. on centers.....3.4 lb.

1–5. Cornerite—Shall be Gold Bond Cornerite.

1–6. Corner Beads—Shall be Gold Bond Corner Bead (specify type).

1–7. Base Screed—Shall be Gold Bond Base Screed (specify type).

1–8. Picture Mould—Shall be Gold Bond Metal Picture Mould (specify type).

1–9. Metal Plaster Arches—Shall be Gold Bond Metal Plaster Arches (specify type).

2. Application of Wood Lath

2–1. General—Lath with wood lath all (exterior stud walls) (wood furred walls) (stud partition) (ceiling beams or joists) (stair soffits), etc., which are specified to be plastered.

Note: It is recommended that ceiling over furnace and fuel room be lathed with gypsum lath or metal lath for fire protection or at least for a distance of 5 ft. beyond all sides of the furnace. Also stud walls enclosing furnace room.

2–2. All lath shall be spaced not less than ¼ in. nor more than ⅜ in. apart, a space of ¼ in. being left between abutting ends and shall be secured at each bearing with 3d lathing nails, using two (2) at each end and one (1) at each other bearing.

2–3. Lath shall be applied at right angles to the supports and joints shall be broken at not more than every seventh lath. No laths shall be carried from room to room. No lathing shall form long vertical joints or be set vertically to fill out at angles or corners.

2–4. Reinforce all re-entrant angles with Gold Bond expanded metal Cornerite and metal corner beads on all exterior angles. All strips shall extend at least 4 in. on each wall and shall butt at ends and not lap and shall be securely nailed or stapled at edges but not in corners.

2–5. Corner Beads—All external corners, both vertical and horizontal, shall be protected with corner beads, of the types or type specified for their full height or length; same to run from top of base to ceiling, heads or beams or to the spring line of arches.

2–6. Where wood lathing on walls, partitions or ceilings abut masonry work, strips of painted metal lath, extending at least 4 in. on each side of the intersection shall be securely fastened. Lath shall weigh not less than 2.5 lbs. per sq. yd.

2–7. Where heat pipes are concealed in walls or partitions, they shall be lathed over with strips of Gold Bond Gypsum Lath or Gold Bond Painted Expanded Metal Lath nailed securely to nearest supports.

2–8. Openings or where studs are spaced over 16 in. wide, as back of medicine cabinets, etc., shall be lathed with expanded metal ribbed lath.

Note: Add here any other special condition requiring metal lath, such as back of tile wainscot, etc.

2–9. Grounds for use with wood lathing shall be ¾ in. thick, including thickness of lath and shall be installed as specified under Carpentry.

3. Application of Gold Bond Gypsum Lath

General—

3–1. Lath with Gold Bond Gypsum Lath all (exterior stud walls) (wood furred walls) (stud partitions) (ceiling beams or joists) (stair soffits), etc., which are specified to be plastered.

3–2. Nailing edges of lath shall have at least ⅝ in. bearing on all studs, joists, etc., the length of the lath laid at right angles to studs. Horizontal joints shall abut, breaking joints in each course. Vertical joints of wall shall be staggered with ceiling joints so they do not meet. Vertical joints on opposite side of partition shall be staggered and not occur on opposite sides of the same stud.

3–3. Nails shall be 3d 1⅛-in., 13 gauge, ⅜-in. head, blued lathing nails spaced approximately 5 in. apart using 4 nails to each stud—16 nails to a 16 x 48 in. panel. First nail about ⅜ in. from edge of panel. Nail center bearing first, then outer edges.

3–4. Fit lath tight together at all re-entrant angles and corners. Fit lath accurately around all electric boxes and similar openings. Cutting shall be done with sharp hatchet or knife and then breaking over a straight edge.

3–5. Where any gypsum lathed wall, partition or ceiling abuts masonry, strips of Gold Bond Reinforcing Mesh or Gold Bond Expanded Metal Lath weighing 2.5 lbs. shall extend at least 6 in. on masonry and 6 in. on gypsum lath, fastening edge to masonry and to gypsum lath.

3–6. All re-entrant angles shall be reinforced over the gypsum lath with Gold Bond Cornerite extending 3 in. each side. Ends shall abut and not overlap.

3–7. All grounds for gypsum lath shall be ⅞ in. thick (including thickness of lath furnished, installed and specified under Carpentry).

4. Application of Gold Bond Gypsum Lath, Perforated or with Aluminum Foil Insulation

Same Specifications as for standard Gold Bond Gypsum Lath.

5. Application of Gold Bond "Floating Wall" System

See page 6 for specifications.

6. Application of Gold Bond Metal Lath

6–1. General—Lath with expanded metal lath all studs and beams for (interior stud walls) (wood furred walls) (stud partitions) (ceiling beams) (furred or suspended ceilings) (stair soffits).

6–2. Application to Wood Supports—Metal lath shall be nailed to wood supports and nails shall be not less than 4d or 6d nails or 1¼ in. in No. 14 gauge wire staples driven to a penetration of not less than ⅞ in. and 1 in., respectively, and fastened every six (6) in. along each support. Side joints shall be wired once between supports.

6–3. All rib lath shall be fastened at all ribs to each support and shall be wired at edges once between supports.

6–4. All metal lath shall be fastened to masonry with special hardened steel nails, self-clinching nails or other device best suited to type of construction.

6–5. Attachment to Metal Supports—Metal lath shall be wired to metal supports at intervals not exceeding 6 in. with not less than No. 18 gauge galvanized soft annealed wire and shall always be tied where sheets lap at channels and at edges once between channels.

6–6. Metal Lath shall be erected with the long dimension of lath across the supports; rib lath with the ribs against the supports.

6–7. Lath shall be first applied to ceilings and the sheets carried down 6 in. on side walls and partitions. If metal lath is not used on the ceilings, the lath shall start at the top of the wall and be bent and carried 6 in. on to the ceiling joists so that no joints shall occur at intersection of ceiling and walls.

6–8. On walls, lath shall be started on one stud away from the corner, be bent into corner and carried onto the abutting wall so as to avoid a joint at juncture of walls. Where ⅜-in. ribbed lath is used on ceilings or walls, it shall be butted into all joints, and strips of lath not less than 8 in. wide shall be bent into the shape of an "L" (Cornerite) 4 in. on each side and shall be securely wired along each edge of the sheet but not in corner.

6–9. Where any wall, partition or ceiling abuts masonry, the metal lath shall extend onto masonry at least 6 in. and be well fastened at edges to joints of the masonry.

6–10. Lath shall be placed so that the lower sheet laps over the upper (not vice versa) and shall be securely attached to supports. Nails or staples shall be so placed that they occur where sides of sheets lap at supports.

6–11. Expanded metal shall be lapped at sides not less than ½ in. and at ends not less than 1 in. End laps shall occur only over supports.

6–12. Ribbed lath shall be lapped at sides by nesting outside ribs, and at ends, 1 in.

All grounds for metal lath shall be ¾ in. thick including the lath and will be furnished and installed as specified under Carpentry.

Note: The metal lath specifications have been adapted from those of the Associated Metal Lath Manufacturers, Inc.

Note: No attempt has been made to include specifications for woven wire lath and many other forms of lath. For these, see Manufacturers' Specifications.

7. Metal Arches, Base Screeds, Corner Beads, etc.

7–1. Metal Plaster Arches—Gold Bond Metal Plastering Arches of the No. and shape as noted hereinafter or on the drawings, shall be securely set in position over the lath in accordance with the details. Corner beads at jambs shall join arch beads accurately without break.

7–2. Corner Beads—All external corners, both vertical and horizontal, shall be protected with corner beads, of the types or type specified for their full height or length; same to run from top of base to ceiling, heads or beams or to the spring line of arches.

Note: If beveled, chamfered or rounded corners are desired, make note where these will occur and change paragraph above.

7–3. Metal Picture Moulds—Gold Bond Metal Picture Moulds shall be installed in the following locations. *(List here, or in schedule of finishes, or on drawings, spaces to have picture mould.)*

Picture moulds shall be accurately set, true and parallel with ceiling line and substantially secured.

7–4. Metal Base Screeds or Wainscot Cap—Gold Bond Base Screed shall be installed in the following locations, *(List here, or in schedule of finishes, or on drawings, spaces to have base screed for base, wainscot cap, etc.)*

Note: Where special items such as metal bases, with or without electric wire ways; chair rails; door and window trim, etc., are desired, they should be included in the proper trade specification according to local jurisdiction.

SECTION 4

PLASTERING MATERIALS—BASE AND FINISH COATS

1. Materials and Mixing

1–1. General—All materials used in plastering shall be stored in a dry place above the ground and shall be handled in such a way as to prevent deterioration or intrusion of foreign matter into the plaster.

1–2. Lime, Gypsum and Cement shall be delivered and stored in original packages of the manufacturer. Any materials in containers showing water marks or which have been damaged or materials that have deteriorated shall be immediately removed from the premises.

1–3. Mixing boxes for base coats shall be clean and tight, approximately 3½ x 7 ft. and 12 in. deep, and 2½ x 4½ x 10 in. deep for finish coats and raised 4 in. at one end. Clean mixing boxes after each gauging.

1–4. Machine mixing shall be permitted in machines made for this purpose if they are cleaned after mixing and kept free of plaster from previous gaugings.

1–5. Tools shall be kept clean and shall not be rinsed in gauging water.

1–6. No more material shall be mixed than can be applied in one (1) hour. Do not mix one gauging with another. Plaster shall not be retempered after it has commenced to set.

Note: Clean water and proper mixing following the direction of the Manufacturer are of extreme importance to good work.

1–7. Plaster shall be kept from freezing for 24 hours after application and no finish coat shall be applied to base which is frozen.

1–8. In hot, dry weather, all openings shall be enclosed with muslin screens or windows kept closed to prevent plaster from drying before it has set; after that, windows shall be opened to permit wall to dry quickly.

1–9. All materials for plastering, except sand, shall be as manufactured by National Gypsum Company, Buffalo, N. Y.

2. Water

Water shall be clean and fit to drink, free from oil, acids, alkali or vegetable matter.

3. Sand

3–1. Sand for base coats shall be sharp, clean and free from saline, alkaline, organic or other impurities. It shall be graded from fine to coarse in conformance with the Standard Specifications for Plastering Sand of the American Society for Testing Materials. Pass through six-mesh screen.

3–2. Sand for finish coats shall all pass a No. 12 screen and shall be white, hard, durable grains free from soluble salts or injurious amounts of organic matter.

4. Plaster

4–1. Base Coat Plaster—Shall be Gold Bond Gypsum Plasters.

4–2. Finish Plaster—Shall be Gold Bond Hydrated Lime Putty with Gold Bond Gauging Plaster or Gold Bond Gypsum Prepared Plaster (specify which).

4–3. Keene's Cement—Shall be Best Bros. Keene's Cement.

SECTION 5

BASE COAT PLASTER—(SCRATCH AND BROWN)

1. Cement Plaster

1–1. On Wood Lath—*Scratch Coat*—Shall consist of one (1) part of fibered plaster to two (2) parts by weight of dry sand.

1–1–1. Soak lath thoroughly 12 to 24 hours before, and again an hour or two before, plastering is started.

1–1–2. Apply in two coats, scratch coat to be applied with sufficient pressure to obtain a good key, filling all spaces between the lath and leaving a light coat over lath. Scratch surface thoroughly to secure bond for brown coat.

1–1–3. Brown Coat—Shall consist of one (1) part plaster (fibered or unfibered; specify which) to not more than three (3) parts by weight of dry sand. Second coat shall be applied as soon as scratch coat is set hard and at least ¾ dry, to a true and even surface. Surface of the second brown coat shall be darbied and broomed to afford a bond for the finish coat.

1–2. On Gypsum Lath or Insulation Lath—Scratch coat shall consist of one (1) part fibered or unfibered plaster to not more than two (2) parts by weight of dry sand.

1–2–1. The Gypsum lath shall not be wetted before applying plaster.

1–2–2. Scratch Coat—Apply with sufficient pressure to work plaster well into the joints. Scratch surface to provide bond for the brown coat.

1–2–3. Brown Coat—Same as above for wood lath.

1–3. On Wire or Metal Lath—

1–3–1. Scratch Coat—Shall consist of one (1) part of fibered plaster to not more than two (2) parts, by weight, of dry sand.

1–3–2. First coat shall be applied with sufficient pressure to obtain good key, lightly covering lath. Scratch surface to secure bond for brown coat.

1–3–3. Brown Coat—Same as for wood lath.

1–4. On Brick, Clay Tile or Gypsum Tile—

1–4–1. Soak brick and clay tile and sprinkle gypsum tile before commencing plastering to reduce suction.

1–4–2. Scratch Coat—Shall consist of one (1) part of fibered (or unfibered) plaster to not more than three (3) parts, by weight, of dry sand.

1–4–3. Apply plaster to thickness of grounds (⅝ in.) in two (2) coats. Apply first coat in thin layer to obtain bond and double back immediately with second coat, straighten to true surface with darby and broom surface for finish coat.

2. Gypsum Sanded Plaster

2–1. Gypsum Sanded Plaster shall be applied same as above for Cement Plaster without the use of sand but with the addition of water.

2–2. Special Sanded Plaster—Shall be used for clay and gypsum tile and brick.

3. Gypsum Wood Fiber Plaster

Note: Wood Fibered Plaster is used invariably for one (1) and two (2) coat work, never three (3) coat work.

3–1. On Wood Lath—

3–1–1. Soak lath thoroughly 12 to 24 hours before, and again an hour or two before, plastering is started.

3–1–2. Scratch Coat—(Mixed with water.) Apply with sufficient pressure to obtain a good key, filling all spaces between the lath and leaving a light coat over lath. Scratch surface to secure bond for brown coat.

3–1–3. Brown Coat—(Mix equal parts of plaster and sand.) Apply to thickness to fill out to grounds and broom surface.

3–2. Gypsum Lath—

3–2–1. Gypsum Lath shall not be wetted before applying plaster.

3–2–2. Scratch Coat—(Mixed with water, no sand.) Apply with sufficient pressure to work plaster well into joints. Scratch surface to provide bond for brown coat.

3–2–3. Brown Coat—(Same as for Wood Lath above.)

3–3. On Wire or Metal Lath—

3–3–1. Scratch Coat—(Mixed with water.) Apply with sufficient pressure to obtain good key, lightly covering lath; scratch surface to secure bond for brown coat.

3–3–2. Brown Coat—(Mixed with equal parts of plaster and sand.) Apply to thickness to fill out grounds and broom surface.

3–4. On Brick, Clay Tile or Gypsum Tile—

Note: Do not specify wood fibered plaster for these bases.

4. Concrete Bonding Plaster (For Use on Concrete Surface)

(See notes regarding preparation of surfaces.)

4–1. Scratch Coat—(Mixed only with water.) Apply in one (1) or two (2) coats with as great pressure as possible, to thickness of not more than ⅜ in. and score heavily for bond of finish coat which shall be applied as thin as possible.

4–2. Gold Bond Wood Fibered Gypsum Plaster—May also be used (unsanded) for concrete surfaces in place of Concrete Bonding Plaster.

SECTION 6

FINISH COAT PLASTER

1. Smooth White Finish

(Lime Putty and Gauging Plaster.)

1–1. Hydrated Lime—Allow to soak twenty-four (24) hours.

1–2. Finish Coat—Shall consist of three (3) parts of lime putty to one part of dry gauging plaster by volume equivalent to two (2) parts of dry, hydrated lime to one (1) part gauging plaster by weight, and shall be thoroughly and uniformly mixed.

1–3. It shall be applied after the base coat is hard, set and about dry. Sprinkle surface of base coat with water before applying finish coat when necessary to kill suction.

Note: Do not apply finish on a base coat containing frost.

1–4. Apply in two (2) coats, first light scratch coat and the second time filling in all imperfections and straighten by means of straight edges.

1–5. Trowel surface to desired finish, keeping wet with brush. Bring same to complete troweling before plaster has set. Surfaces shall be perfectly true and even without scratches, ridges, waves, chips, voids, cracks, etc. All angles must be true, sharp, straight and clean.

2. Prepared Gypsum Finish (Using Gold Bond Trowel Finish Plaster)

2–1. **Finish Coat**—Plaster is ready after thoroughly mixing with water, allowing to soak for ten (10) minutes without hoeing. Make mix very thin and creamy.

2–2. Base coats must be set and hard and about ¾ dry. If too dry, cut suction by sprinkling with clean water.

2–3. Apply finish in three coats; first coat applied as thin as possible to handle and scratch thoroughly into base coat. Let draw for a few minutes, then apply second coat, leveling up. Apply third coat as thin as can be handled, filling in cat faces and imperfections. Let draw and then trowel to smooth surface, applying water sparingly with brush, but not enough to kill face of plaster. Avoid joinings by working top and bottom of wall at same time. Finish coat shall not be less than 1/16 in. or more than 1/8 in. thick.

3. Sand Float Finish (Using Gold Bond Sand Float Finish)

3–1. Using Prepared Sand Float Finish—add water only.

3–2. Base coats must be set and hard, about ¾ dry, before applying finish coat.

3–3. Finish shall be applied with trowel, scratch in thin coat, then double back with second coat to bring to even, level surface free from surface marks. Use float (carpet) (felt) or (cork) to bring to final, even, granular finish. Apply water sparingly with brush, being sure to complete floating before plaster has set. Avoid joinings by working top and bottom of wall at same time. Finish coat shall not be less than 1/16 or more than 1/8 in. thick.

4. Keene's Cement Lime Trowel Finish

4–1. **Finish Coat**—Shall consist of three (3) parts of Keene's Cement to one (1) part of lime putty by volume (or 100 lbs. dry Keene's Cement to 40 lbs. lime putty).

4–2. Base coats must be set and hard but not thoroughly dry before applying finish coat. If base coat is dry, spray slightly with water but do not soak.

4–3. Apply thin coat well scratched in, then double back and fill out to even surface. Allow to draw for a few minutes, then trowel and brush to a smooth finish, using as little water as possible while troweling. Thickness shall not be less than 1/16 in. or more than 1/8 in.

4–4. **Imitation Tile**—Marked off for imitation tile, the thickness shall depend on depth of scoring but in no case should be less than 1/16 in. at bottom of scoring.

4–5. **Polished Surface**—After cement is dry, polish with a cloth to a high polish.

5. Texture Finish (Gold Bond Color Texture)

Over Gypsum Base Coats—Where used over two-coat gypsum plaster, walls should be floated before application of Color Texture to increase yardage and give more uniform job. Dry walls may be sized or dampened to increase yardage and give longer time for texturing.

Over Lime Finish—It is not good practice to apply Color Texture or any other decorative material over fresh lime putty finish, sooner than four months after application of the lime putty. If, however, it is desirable that the walls be decorated at once, Gold Bond Color Texture can be applied as soon as the lime putty is thoroughly set and dry. **The lime must not be sized.**

Color Texture may be applied over old lime putty walls with or without sizing. Follow detailed instructions packed in every carton.

SECTION 7

ORNAMENTAL PLASTER WORK

1. Cornices and Mouldings

1–1. Cornices and Mouldings of size or girth required should be specified, shown on drawings or noted in schedule of finishes.

2. Ornamental or Enriched Work

2–1. Ornamental or enriched work should also be shown on details, character desired described in specifications and noted on schedule of finishes.

3. Models

3–1. All ornamental work shall be executed from models approved by the Architect.

3–2. Models shall be furnished under a cash allowance of () which shall be included by this Contractor in his contract. Models shall be executed by a modeler (selected by) (satisfactory to) the Architect, and the work shall be executed under the direction of the Architect. Models shall be delivered by the modeler at his studio, ready packed, to this Contractor who shall pay all charges of transportation.

3–3. Models shall be furnished to this Contractor without cost to him by the Owner. Models shall have been prepared under the direction of the Owner.

4. Materials

4–1. Materials shall be Gold Bond Moulding Plaster for run mouldings and ornamental work.

4–1–1. *Mixing*—Add water only to Gold Bond Moulding Plaster.

5. Run Work

5–1. Run Work shall be run full, true and even in accordance with Architect's details. All curved work shall be run true to radius.

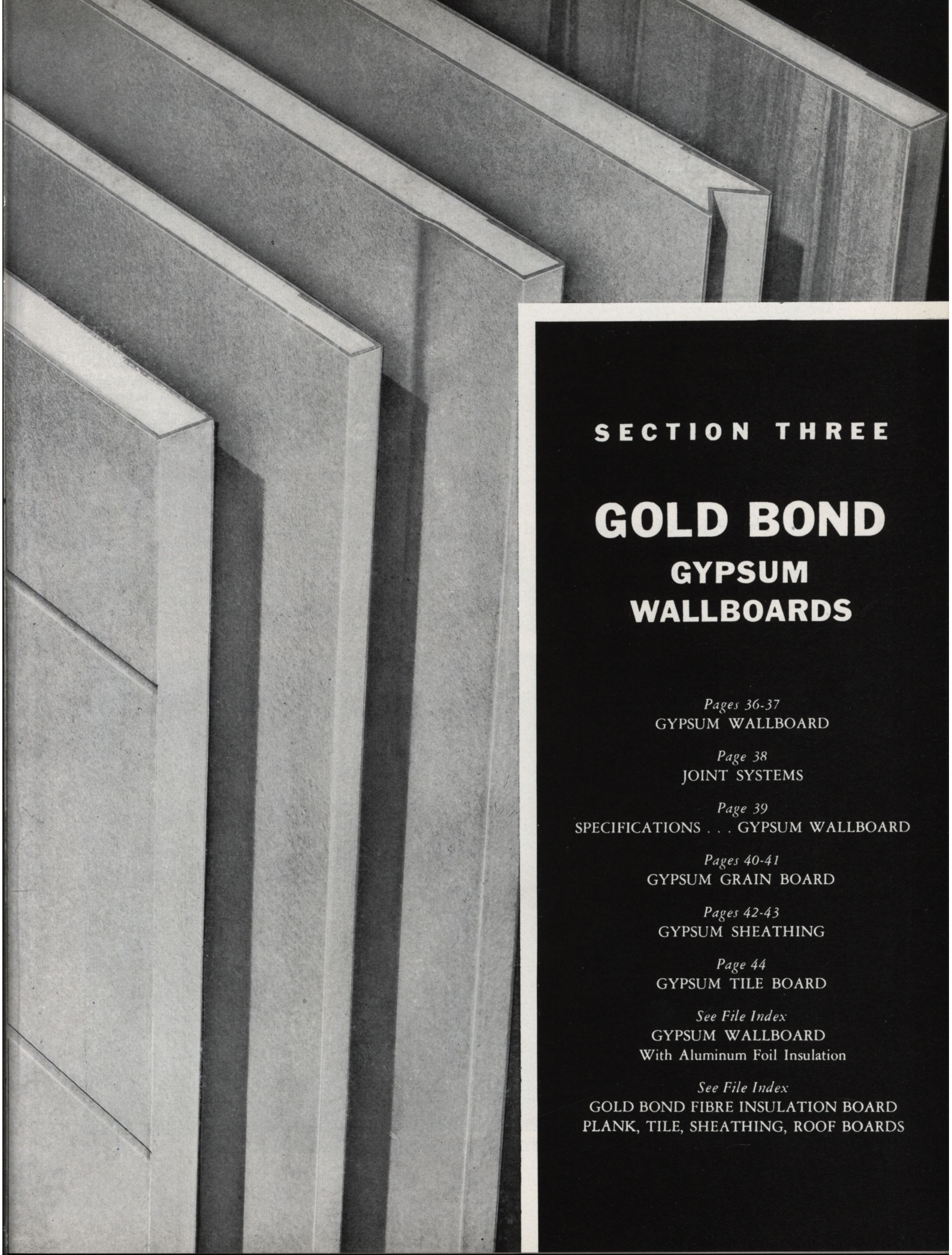
5–1–1. *Templates*—Shall be of metal, clean cut and accurate with the Architect's full-size details.

6. Cast Work

6–1. All enriched work and ornamental work which cannot be run in place on the job, shall be of best quality, cast from gelatine moulds. All work shall be properly backed, cast solid or hollow, and properly reinforced with wood or iron, and shall be securely stuck and held in place with copper wire.

6–1–1. Cast ornamental coffered ceilings shall be cast in sections and reinforced so that sections can be secured to hangers or other support from ceiling slabs, etc.

6–1–2. All cast work shall be set true in surface and alignment and any rough spots shall be finished and sand papered and left perfect, ready for decoration.



SECTION THREE

GOLD BOND GYPSUM WALLBOARDS

Pages 36-37
GYPSUM WALLBOARD

Page 38
JOINT SYSTEMS

Page 39
SPECIFICATIONS . . . GYPSUM WALLBOARD

Pages 40-41
GYPSUM GRAIN BOARD

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GYPSUM SHEATHING

Page 44
GYPSUM TILE BOARD

See File Index
GYPSUM WALLBOARD
With Aluminum Foil Insulation

See File Index
GOLD BOND FIBRE INSULATION BOARD
PLANK, TILE, SHEATHING, ROOF BOARDS

GOLD BOND GYPSUM WALLBOARD

The Pioneer Lightweight Gypsum Wallboard, Made Under Exclusive Patents . . . Fireproof, Non-Warping Three Finishes: Plain, Tile, Imitation Wood-Grain

GYPSUM wallboard in its present highly efficient form is relatively a new-comer to the building products field. Prior to 1925, when NATIONAL GYPSUM COMPANY was organized, gypsum boards weighed about 2000 pounds per thousand square feet. They were brittle, breaking easily, and chipping along the nailing edge. Because of their excessive weight and fragility, their use was limited.

Gold Bond Changes Industry

Then in 1925, came Gold Bond with patents covering a revolutionary type of gypsum wallboard. The new product weighed 1700 pounds against the old 2000 pound weight . . . it was much stronger . . . its millions of tiny air cells gave insulation never before dreamed of in gypsum wallboard. Overnight gypsum wallboard became a practical building material, with a hundred-and-one uses in remodeling homes, stores, factories, offices, garages, and all types of building.

New Patents for Lighter Board

Years of pioneering followed, during which time Gold Bond continued to improve the quality of its board. Gold Bond engineers were unceasingly at work in an endeavor to further lighten and strengthen gypsum wallboard. They succeeded. And in April, 1934, United States patent numbers 1,932,956 and 1,946,077 were issued covering the manufacture of a gypsum wallboard of extremely light weight plus super-strength.

This important improvement was brought about through a unique method of greatly increasing the number of tiny, dead air cells in the gypsum core. The new board, although lighter in weight, is stronger, more flexible or resilient, higher in insulation value. And it may be nailed close to the edge without splitting.

Exceeds Federal and ASTM Specifications

The National Gypsum Company guarantees its gypsum wall board products to exceed by 100% the strength requirements of Federal Specifications SS-W-51 A and ASTM specifications C-36 for gypsum wallboard, and to meet all other requirements of these specifications.

New Products Introduced

Following the perfection of standard Gold Bond Gypsum Wallboard, Gold Bond Gypsum Tile was announced, followed by Gold Bond Gypsum Wallboard with Aluminum Foil Insulation and Gold Bond Grain Board, which in texture and grain gives the effect of wood paneling at a great saving in cost. The latter product is made in three distinctive finishes—Gumwood, Mahogany and Knotty Pine and comes already lacquered.

In addition to the standard board with Square Edge as pictured below, Gold Bond Board is also made with Recessed Edge and T. and G. Edge as shown on the preceding page. There are three thicknesses: ¼ inch, ⅜ inch and ½ inch.

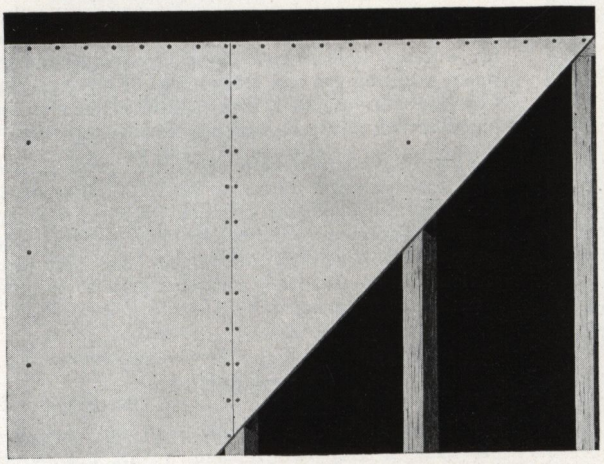
For Gold Bond Gypsum Wallboard and Lath with Aluminum Foil Insulation, See File Index.



A panel of ⅜ in. Gold Bond Gypsum Wallboard showing the distinctive edge label

Panels Applied Vertically

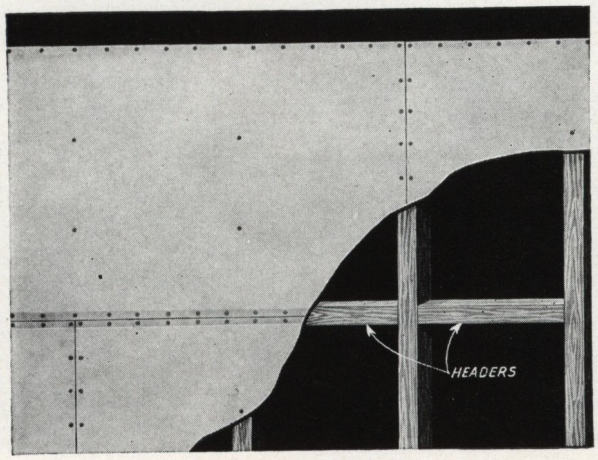
¼ or ⅜-in. Gold Bond Gypsum Wallboard, should be applied vertically or parallel with studs. Use headers (extra 2 x 4's) where necessary to provide a solid backing at all edges.



Nails at edges are spaced 3 in. apart and ⅜ in. in from edge of panel. Center nails (to the intermediate studs) are spaced 6 in. apart on walls; 9 in. apart on ceilings.

Panels Applied Horizontally

½-in. Gold Bond Gypsum Wallboard with Recessed Edge or T. & G. Edge should be applied horizontally or crosswise to studs, which provides greater structural strength. With T. & G. Board, the groove edge should be down.



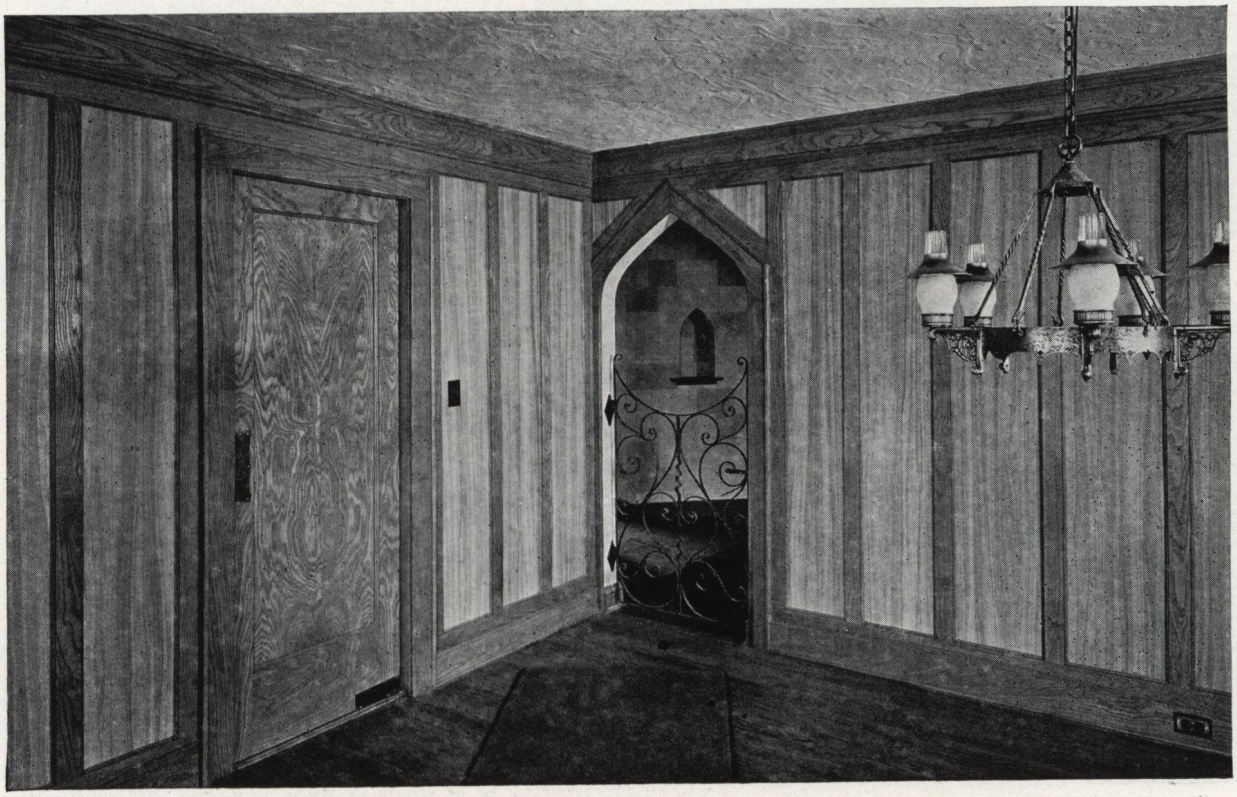
Work from ceiling to floor, applying the top panel first. Use headers (extra 2 x 4's) where necessary to provide a firm backing at all edges. Stagger vertical joints.

Fireproof . . . Won't Warp, Expand or Contract

Gold Bond Gypsum Wallboard is fireproof and provides valuable protection for wood framing members. The core is solid gypsum rock. Tests prove the fire resistance of Gold Bond is unexcelled by any other gypsum wallboard. Panels are unaffected by dampness or climatic changes and will not warp or buckle because there is no expansion or contraction.

Sizes and Thicknesses

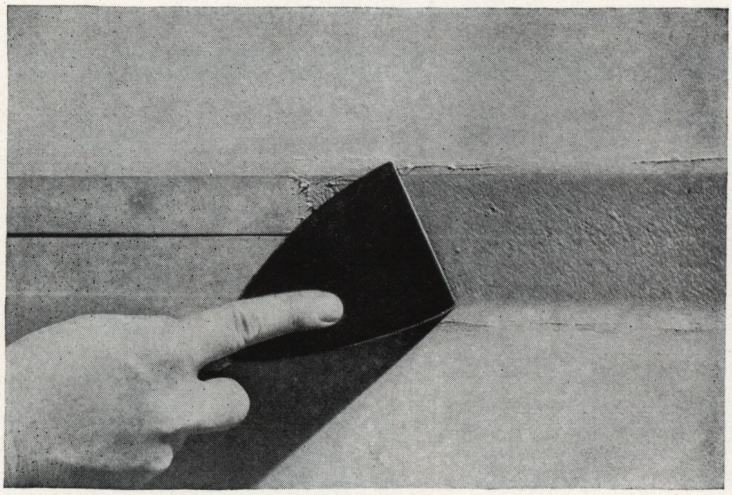
Thickness	Width	Length
¼ in. Square Edge	48 in.	4, 5, 6, 7, 8, 9, 10, 11, 12 ft.
⅜ in. Square Edge	48 in.	4, 5, 6, 7, 8, 9, 10, 11, 12 ft.
½ in. Square Edge	48 in.	4, 5, 6, 7, 8, 9, 10, 11, 12 ft.
⅜ in. Recessed Edge	48 in.	8, 9, 10 ft.
½ in. Recessed Edge	36 and 48 in.	8, 9, 10 ft.
½ in. T. & G. Edge	48 in.	8, 9, 10 ft.



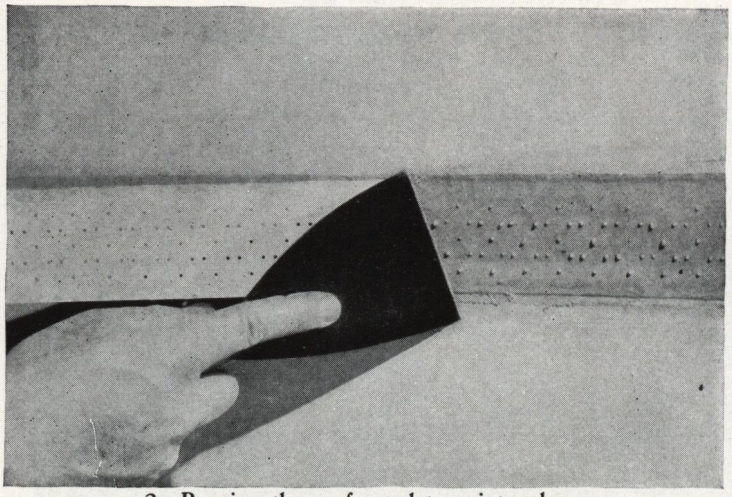
Another charming room . . . Gold Bond Grain Board for the walls, Standard Gold Bond Gypsum Board for the ceiling decorated with Gold Bond Color Texture.

GOLD BOND PERFORATED TAPE JOINT SYSTEM

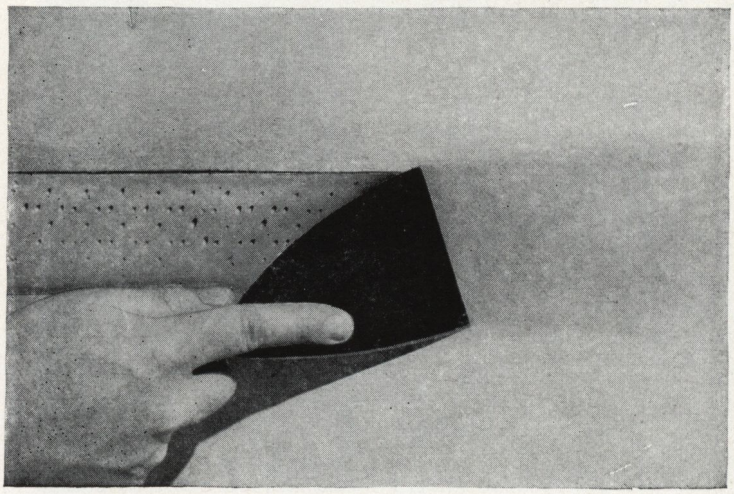
A Simplified Method of Concealing Joints of Gypsum Wallboard for a Smooth, Seamless Wall, Ready for Decoration



1. Filling the channel with cementing plaster



2. Pressing the perforated tape into place



3. Smoothing surface and feathering out edges

Gold Bond Perforated Tape Joint System is for use with any style of Gold Bond Gypsum Wallboard, square edge, tongue and groove edge or recessed edge. Comprises the use of a fibre perforated tape in conjunction with a smooth-working cementing plaster.

This System works particularly well with recessed edge board because the recess along the edge of the panel forms a perfect channel for the tape and cement. The pictures at the left show the easy steps in applying. If normal care is used, the panel intersections can be completely concealed prior to painting, papering or texturing.

Application

Fill the hollow or channel with the cement as illustrated in Step No. 1, using a 5-in. putty knife. The cement should extend ½ in. beyond the edge of the channel. Apply the perforated tape immediately, directly over the cement and press it into place with the putty knife which automatically forces some of the cement through the perforations, as shown in Step No. 2.

The cement forced through the perforations should be smoothed over with putty knife and allowed to dry. Next, apply another thin coating of cement so that the tape will be completely hidden. Feather out edges as smoothly as possible and let dry thoroughly. Intermediate nail heads should also be carefully filled with cement and brought flush with the surface of the board. The last operation is sanding the treated joints and the filled nail heads with coarse and then fine sandpaper.

Coverage

Standard size carton contains one 250-ft. roll of Perforated Tape and cementing plaster—enough for 550 to 650 sq. ft. of Gypsum Wallboard.

Small size carton contains one 25-ft. roll of Perforated Tape and cementing plaster—enough for 55 to 65 ft. of Gypsum Wallboard.

GOLD BOND FINISHER

For an Inexpensive, Quick Job

Gold Bond Finisher is mixed with water to a putty consistency and applied with putty knife between the panel intersections and over the exposed nailheads. When thoroughly dry, is sandpapered smooth. Supplied in 5 lb. packages. . . . Of course, it isn't possible to do as good a job with Finisher as with Perforated Tape Joint System nor will the joints be as strong as when reinforced with the perforated tape and special cementing plaster.

STANDARD SPECIFICATIONS
FOR APPLICATION OF GOLD BOND GYPSUM WALLBOARD

1. Scope of Work

List all walls, ceilings and other surfaces which are to be covered with Gold Bond Gypsum Wallboard.

2. Framing

2–1. Framing of all studs and joists shall be 16 in. on center, unless for bearing partitions which are 12 in. on center, and shall follow general good practice.

2–2. Headers of 2 x 4 in. shall be provided in ceilings and wherever else required to provide proper nailing for all ends of Gold Bond Wallboard . . . also between studs for baseboards, wainscot, or other finish, and for furring to take wood beams, cornices, etc.

2–3. For old plaster ceilings, nail 1 x 2 in. furring strips over the plaster, to provide proper nailing for ends and intermediate support of boards, using 8d nails.

3. Material

3–1. Wallboard—Where wallboard is referred to hereinafter, it shall mean Gold Bond Gypsum Wallboard as manufactured by National Gypsum Company, Buffalo, N. Y.

3–2. Gold Bond Wallboard shall be (¼ in.) (⅜ in.) thick in lengths to run full height on walls from floor to ceiling and to headers on ceilings.

Note: Where ½-in. Gold Bond Wallboard with T. & G. Edge or Recessed Edge is used, it shall be applied at right angles to studs and joists.

3–3. Nails for ¼ in. and ⅜ in. Gold Bond Wallboard shall be 3d, blued nails 1⅛ in. long for use over studs, joists or beams. For ½-in. board use 4d nails 1⅜ in.

3–4. For directly over old plaster use 6d cement coated common nails 1⅞ in. long.

3–5. Where ceiling has floor above use 4d cement coated nails, 1⅜ in. long for ceiling wallboard.

4. Handling and Preparation

4–1. Receiving Material—Wallboard shall be piled flat on floors with reverse side up except first board which shall be turned down.

Note: (Wallboard shall not be delivered on the job until doors and windows are in place.)

4–2. Handling—Wallboard shall be handled with long edge up.

4–3. Sawing and Cutting—All required cutting of wallboard shall be done with a saw unless joints will be covered by trim. Sawing shall be done with sharp handsaw with back of board placed down and supported close to sawed edge. Other cuts may be made by scoring with sharp edge of hatchet or chisel and breaking over straight edge. Bevel the face side of cut edges and mill cut end with coarse sand paper so that no rough paper edges will remain, unless covered by trim. Recut the ends of all wallboards which have been damaged by handling.

5. Application

5–1. Inspection—Before applying wallboard see that all edges and ends are perfect and all ends and cut edges are face beveled and that faces of boards are undamaged.

5–2. Wallboard, with back toward studs, shall be applied directly to studs, beams, etc. Horizontal joints shall be made only over framed headers.

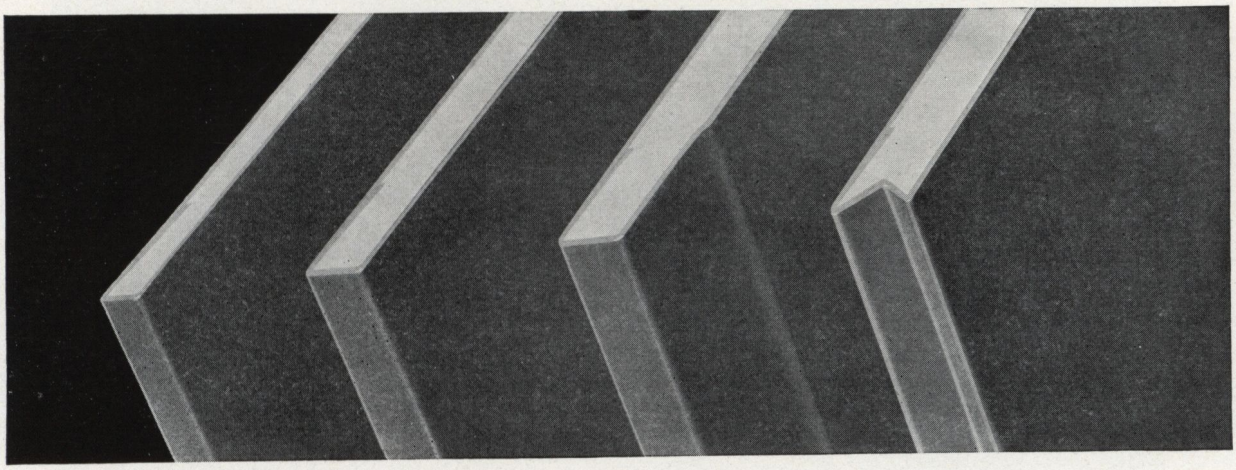
Note: All closed edges of panels shall be butted together. Sawed edges (with gypsum core exposed) or mill-cut ends shall be spaced ⅛ in. apart.

5–3. Nailing—Wallboards shall be nailed first to intermediate studs or beams and nails driven straight in, with heads set slightly below the surface without using nail set. Nails shall be spaced 9 in. apart on intermediate studs of walls and 6 in. apart on ceilings. Nails shall be spaced 3 in. apart and ⅜ in. back from all edges and ends. Boards shall first be tacked on edge to hold to adjoining edge and then shall be nailed first to each intermediate support working from center toward ends and finally sides and ends shall be nailed, with nails opposite each other on edges.

5–4. Ceilings—Ceiling boards shall be erected first and length of board shall be at right angle to ceiling beams. Panels shall be in one piece as far as possible but if joints occur they shall be broken unless covered with strips or wood beams.

5–5. Walls—Wallboard shall be applied in full lengths from floor to ceiling and parallel to framing. (½-in. Wallboard with Recessed Edge or T. & G. Edge shall be applied at right angles to framing with groove edge down and the full length panels shall extend above and below openings instead of "piecing." This adds greater structural strength.) Vertical joints on opposite sides of partitions shall not come opposite each other on the same stud.

Showing the Three Edges in which Gold Bond Gypsum Wallboard is made



Square Edge Square Edge Recessed Edge T. & G. Edge

GOLD BOND GRAIN BOARD

All the Richness of Expensive Wood Paneling at a Fraction of the Cost . . . Three Finishes: Gumwood, Mahogany, Knotty Pine

Gold Bond Grain Board is standard gypsum board with an imitation wood grain surface that defies detection upon casual inspection. Made in three distinctive finishes—Gumwood, Mahogany and Knotty Pine.

In addition to its rich-looking grain surface, Gold Bond offers these important advantages over real wood: the solid gypsum core is fireproof and unaffected by dampness. Won't expand, contract, warp or peel. Saws like lumber and may be nailed without splitting. Installations made years ago, show not the slightest tendency toward fading.

Where Used

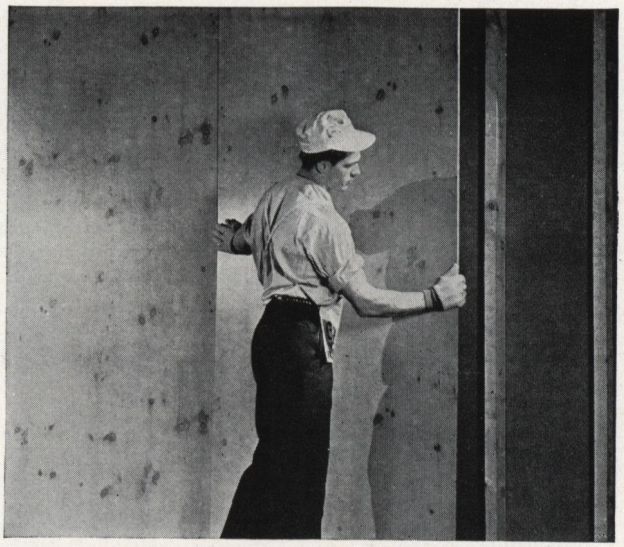
Millions of feet of Gold Bond Grain Board have been used in offices, stores, restaurants, taverns, living rooms and dining rooms in private homes, window backgrounds . . . in fact, wherever an impressive wood panel effect is desired.

For Summer Cottages and Recreation Rooms

The low cost of Gold Bond Grain Board—only a fraction as much as real wood—permits its use for even low priced summer cottages and recreation rooms. Besides offering a durable interior finish that is very unusual and beautiful, the cellular gypsum core provides effective insulation so much desired in summer homes. For basement recreation rooms, Gold Bond is strongly recommended . . . it is not affected by cellar dampness and won't warp.

Supplied With Lacquer Finish

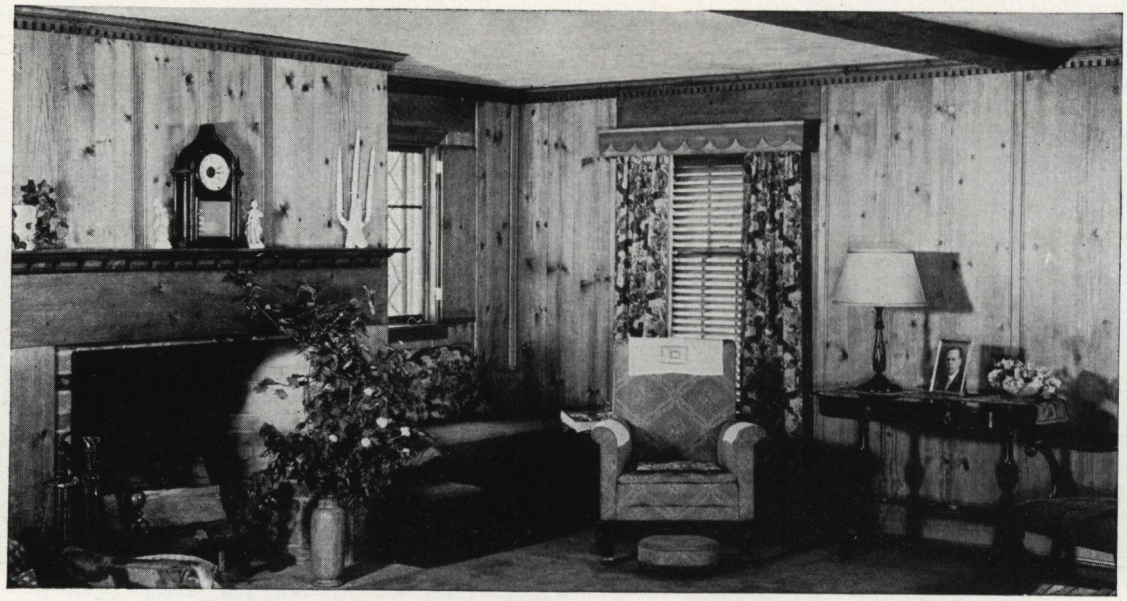
Made with a protective lacquer finish which can easily be cleaned with a damp cloth. No further decorative treatment is necessary, but like real wood, additional finishing will bring out its full richness. The simple instructions for further decorative treatment are given on the next page.



Sturdy panels of Gold Bond Grain Board are nailed to the wood framing or, if modernizing, right over the old material. Old fashioned rooms with cracked walls and ceilings can be quickly converted into attractive up-to-the-minute interiors, and at surprisingly low cost.

Thickness and Sizes

Standard thickness, 3/8 in. (Special thickness, 1/4 and 1/2 in.) Gumwood and Mahogany panels are made 32 in. wide and 8, 9, and 10 ft. long. Knotty Pine, 48 in. wide and 8, 9, and 10 ft. long. All panels are carefully wrapped, two to a bundle.



A beautiful room, delightfully different . . . Gold Bond Knotty Pine.

APPLICATION INSTRUCTIONS

Nailing

Gumwood and Mahogany (32 In. Wide)—Space studs 16 in. on centers, using headers (extra 2x4's) where necessary to provide firm nailing surface behind the four edges of each panel. Nails should be spaced 3 in. apart and ⅜ in. in from edge of panel. On sidewalls *only*, it is not necessary to nail the center of the panel to the intermediate stud—this middle stud merely serving as a brace or support behind the center of the panel. Butt the panels together. Nail along the four edges, beginning at the center and working towards the top and bottom.

Knotty Pine (48 In. Wide)—Follow above procedure except the panels must be nailed to the intermediate or middle studs as well as at the four edges. Do the intermediate nailing first beginning at the center of the panel and working towards the top and bottom. Use 4d finishing nails for the intermediate nailing driven at a 45 degree angle. Use care not to mark the board with the hammer. Intermediate nails should be driven just a trifle below the surface so the heads can be concealed with linseed oil putty mixed with stain.

Nails—For new work, use 3d cement coated flat-head nails 1⅛ in. long around the edges. Over old material use 6d cement coated flat-head nails 1⅞ in. long. Drive the nails "home" but do not use a nail set. For intermediate nailing, use 4d finishing nails.

Paneling

Gold Bond Grain Board may be used with or without decorative mouldings over the joints. To obtain a well balanced paneled effect, it is well to prepare a plan in advance for the carpenter to follow.

Or if a paneled effect is not desired, the Grain Board panels can be butted together so that the joints are hardly visible. For the latter treatment, finishing nails should be used around the edges instead of flat-head nails and the nailheads concealed with linseed oil putty mixed with stain.

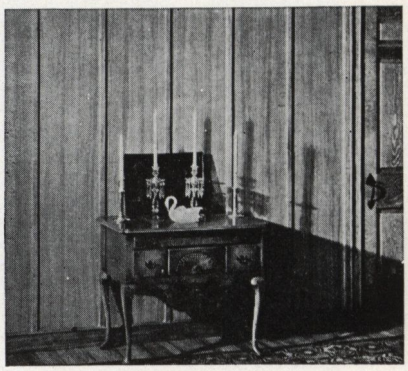
Decoration

As Gold Bond Grain Board comes already lacquered, no further decoration is needed. May be cleaned by going over it lightly with a damp cloth. Like real wood, additional finishing will, of course, improve the richness. Always apply a priming coat (equal parts of white shellac and alcohol). Follow with a coat of clear (flat or dull) varnish or an emulsified floor wax. The dull varnish finish is particularly recommended. Rub down lightly between coats with steel wool.



A Close-up Showing the Distinctive Wood Graining

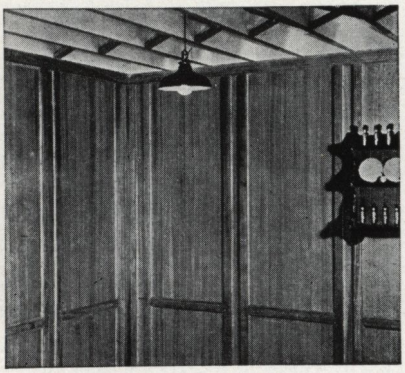
Three Home Views Created by Joseph Platt of Delineator Showing Treatments Obtainable with Gold Bond Grain Board



Dining Room



Sun Room



Recreation Room

GOLD BOND GYPSUM SHEATHING

For Use Under Wood Siding, Clapboards, Brick-Veneer, Stone or Stucco . . . Full 1/2-inch Thick . . . Fireproof Solid Gypsum Core Real Fire Protection for the Wood Frame Home

Description

GOLD BOND GYPSUM SHEATHING is a sturdy, knotless sheathing material, full ½ in. thick. The core is solid gypsum rock, encased in heavy, waterproofed building paper with tongue and groove edges. Is rapidly becoming the leading sheathing material because it offers these distinct advantages:

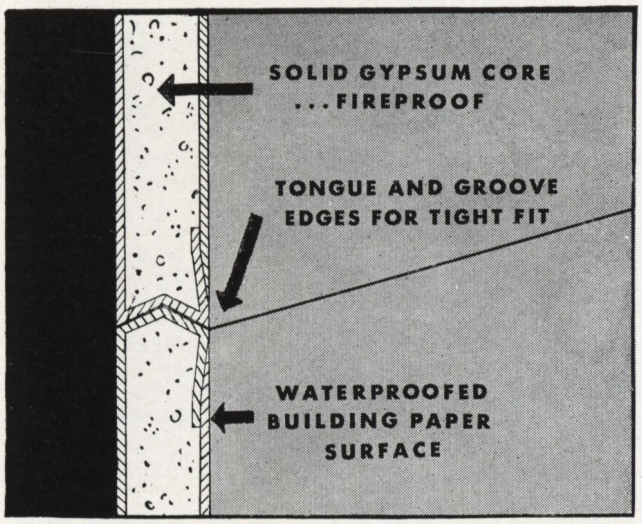
Fireproof	Won't warp, expand or contract
Water-resistant	No building paper required
Windproof	Won't absorb moisture and freeze
Helps insulate	Saws like lumber
Adds structural strength	Costs less . . . Saves labor

Gold Bond Gypsum Sheathing is absolutely non-inflammable and incombustible. It insures permanent fire protection for wood frame houses at no extra cost. Solid gypsum core resists water effectively and additional protection is provided by the heavy, waterproofed paper on both sides.

Easier to Apply

The large sturdy panels go up in no time—an 8-ft. length covering a span of 6 studs spaced 16 in. on centers. Use 10½-gauge flat head roofing nails 1¾ in. long.

Contractors report a further saving can be effected in applying the panels, by working from the inside of the house, thereby eliminating the usual outside scaffolding.



Gold Bond Sheathing, Full ½-In. Thick, with Core of Solid Gypsum Rock. Long Edges Are Tongue and Groove, Which Make Snug Windproof Joints. Ends Are Perfectly Square.

Won't Warp or Buckle

There is positively no movement in the panels regardless of climatic changes or extreme weather conditions. No possibility of shrinkage, leaving open gaps along the joints.

Windproof . . . Helps Insulate

The infiltration of hot or cold air is effectively stopped by Gold Bond Gypsum Sheathing. This can easily be appreciated when one considers:

First—The wide panels (2 ft.) greatly reduce the number of joints and these are permanently snug because of the tight-fitting tongue and groove edges.

Second—The panels are knotless. No danger of knots falling out after application, leaving holes for wind to enter.

Size, Thickness, Weight

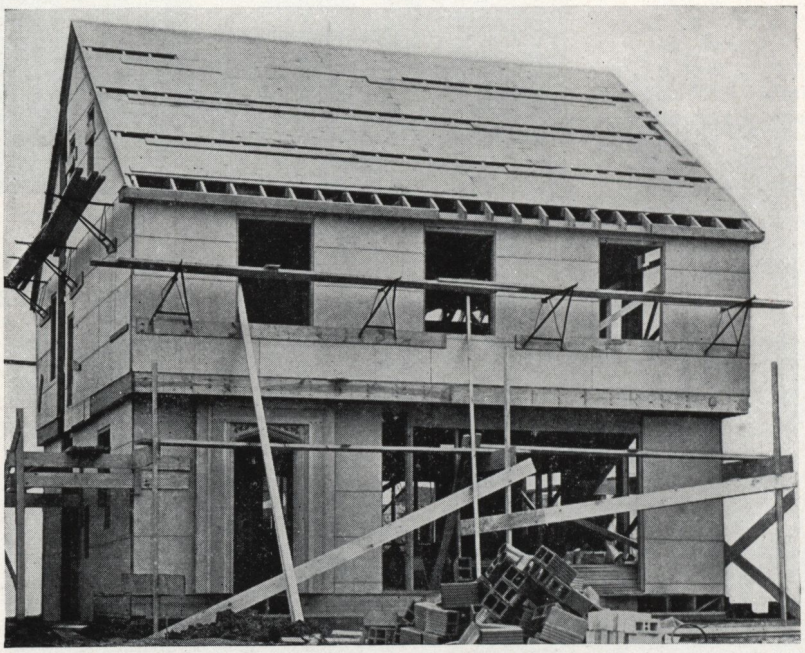
Sizes: 2 ft. x 8 ft., 2 ft. x 6 ft. 8 in.

Thickness: Full ½ inch.

Weight: Approx. 1900 lbs. per M sq. ft.

Edges { Long edges T. and G.
Short edges square

One thousand square feet actually covers one thousand square feet of surface. No random lengths and no waste.



Large, Sturdy Panels of Gold Bond Sheathing Go Up in No Time, an 8-Ft. Length Covering a Span of Six Studs Spaced 16 In. on Centers. No Random Lengths and No Waste. Building Paper Is Not Required.

GOLD BOND GYPSUM SHEATHING (Cont'd)

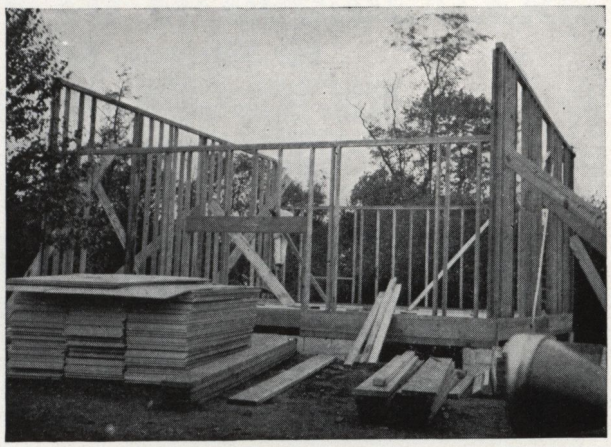
Adds Structural Strength

As indicated by the following chart, ½ inch Gold Bond Sheathing adds greater structural strength to a building than other sheathing materials applied horizontally or diagonally.

Comparative Structural Strength

GYPSUM SHEATHING vs. WOOD SHEATHING
Tests Made at Armour Institute of Technology
(Test Panels 4'x8' . . . made of yellow pine 2x4's spaced 16" on centers)

LOAD IN POUNDS	YELLOW PINE SHEATHING 7/8" x 8"		GYPSUM SHEATHING
	Applied Diagonally	Applied Horizontally	Applied Horizontally
	Deflection in Inches	Deflection in Inches	Deflection in Inches
100	.01	.10	.00
800	.10	2.56	.07
2000	.29	10.94	.20
2800	.54	11.72	.32
3600	1.07		.54
4000			.84
Load at end of test	3925 lbs.	3150 lbs.	4425 lbs.



Builders everywhere are swinging over to this fireproof sheathing. Note the trim piles of Gold Bond in the foreground — absolutely uniform in size and thickness. No danger of "losing" them for kindling wood because they won't burn.

Specifications

(1) Sheathing and Roof Boards—Sheathing and Roof Boards shall be Gold Bond Gypsum Sheathing as manufactured by National Gypsum Company, ½ in. thick, 2 ft. wide, 8 ft. long (or 6 ft. 8 in. long). Nails shall be 1¾ in. long, No. 10½ gauge, galvanized flat head roofing nails. Protect panels from the weather until ready for use.

(2) Application—Apply panels of Gold Bond Sheathing directly to supports with lengths at right angles to the studding and rafters with groove edge down and trade-mark in.

Wherever the square ends shall be butted together a support shall be provided and the tongue and groove sides shall be fitted tightly together. Stagger vertical joints.

Panels shall be nailed to each intermediate support and at the ends, the nails to be spaced 4 in. apart and ⅜ in. in from edge at the ends. (49 nails to each 2x8 ft. panel.) Building paper shall not be used over Gold Bond Sheathing.

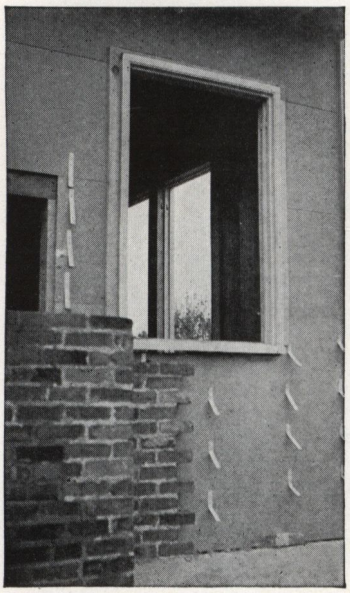
(3) Siding—Apply siding at right angles to studding, directly over Gold Bond Sheathing. Siding shall be nailed into the wood supports (not to the sheathing) and nails shall be long enough to go through the sheathing and into the studs.

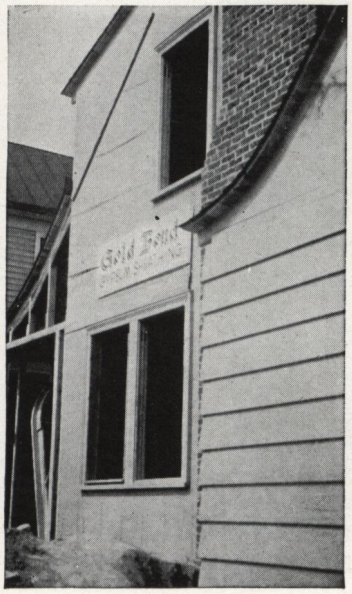
(4) Shingles—Apply 1x2 in. wood furring strips over Gold Bond Sheathing at right angles to studding, to take shingle weathering specified. Furring strips to be nailed securely through the sheathing to the studding.

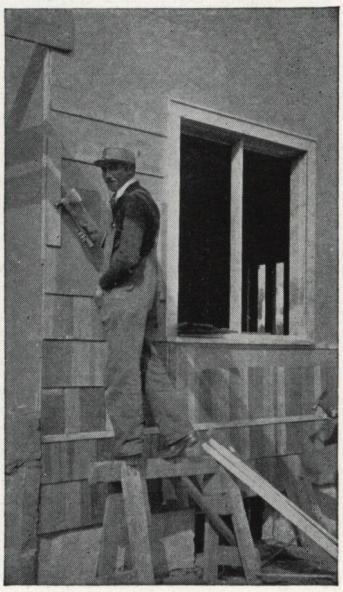
(5) Stucco—Use 2.5 Gold Bond Self-Furring Diamond Mesh Lath Galvanized over the sheathing. Nail securely through sheathing to the wood framing.

(6) Stone or Brick—Wall ties shall be nailed securely through the sheathing to the wood supports.

Showing Gold Bond Gypsum Sheathing, Used with Various Types of Exterior Finish.

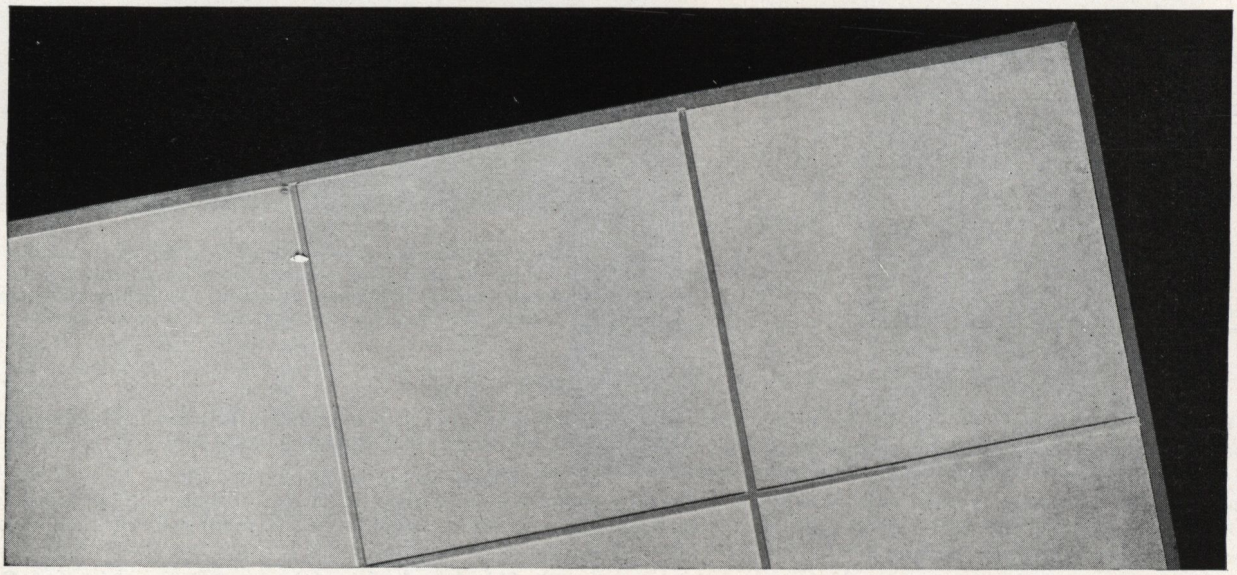






GOLD BOND GYPSUM TILE BOARD

For Kitchens, Baths, Restaurants and Stores
Large, Easily Applied Panels with Deep, Clean-cut Tile Indentations
Costs Only a Fraction as Much as Ceramic Tile



Section of Gold Bond Tile Board Showing Embossed Tile Effect. Actual Size of Tile is 4 Inches Square

GOLD BOND TILE BOARD is made under the same processes as Gold Bond Gypsum Wallboard except that the surface is indented to form tile, four inches square. Is fireproof; will not crack, expand or contract and takes a beautiful enameled finish.

Gold Bond Tile Board is ideal for new and modernizing work and costs but a fraction as much as ceramic tile. Saws like lumber and can be applied quickly with little muss or dirt.



An Ideal Combination—Gold Bond Tile Board for the Wainscot and Standard Gold Bond Board decorated with Gold Bond Color Texture or Craftex for the upper walls and ceilings . . . Inexpensive . . . Permanent . . . Washable.

Thickness and Sizes

Panels are ⅜ in. thick and supplied 4 ft. wide and 6, 7, 8, 9 and 10 ft. long. In kitchens and baths of average size, one panel will extend the full length of the wall with no joints except at the corners where a quarter round mould is generally used.

Application and Decoration

Nail panels directly to wall studs or if remodeling, apply over present material. Use flat head nails along the edges, spaced 3 in. apart and ⅜ in. in from edge. Nails should be at least 1⅛ in. long or approximately 2 in. if used over old material. Panels must also be nailed to intermediate studs with finishing nails, these nails to be spaced 8 in. apart (or every two tiles from the top to the bottom of panel). Drive nails "home" but do not use a nail set.

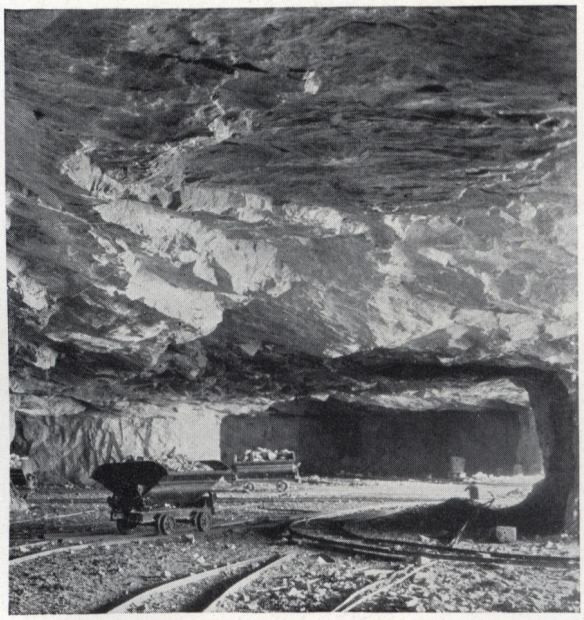
Apply a priming coat of varnish size. Then a coat of paint, followed with a second coat of paint or enamel. Rub down between coats with fine sandpaper or steel wool.

Contrasting Colored Indentations

Give surface a coat of flat paint or enamel undercoating of the finished color desired for the indentations. Then apply a coat of enamel in some contrasting color, brushed on very thin. When enamel has set, wipe out the joints with any narrow tool such as a ruler, match, or ordinary meat skewer. It is advisable to stretch a piece of cloth over the end of the tool to absorb the enamel that is wiped out of the indentations, taking care to keep the cloth clean. This brings out the color of the base coat or undercoating at the indentations and produces an attractive two-color job.

A CHAIN OF 14 MAMMOTH GOLD BOND PLANTS INSURES QUICK SERVICE TO 10,000 DEALERS

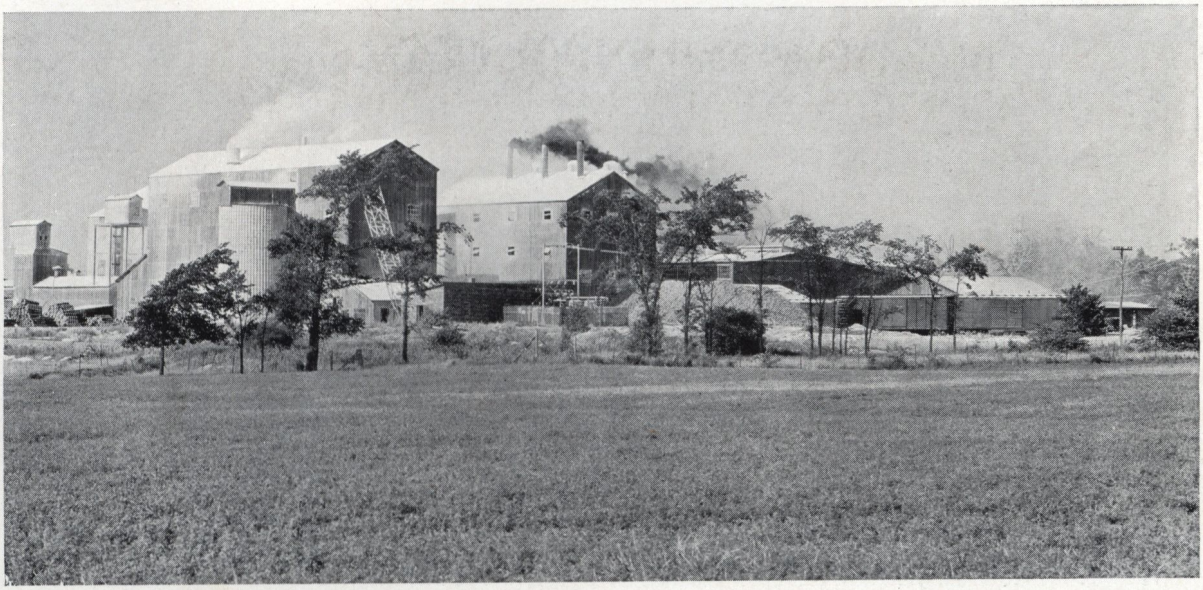
Uniform High Quality Is Insured by Constant Supervision from the Time the Raw Materials Are Taken from the Mines Until the Finished Products Are Loaded in the Cars.



Lime Mine at York, Pa. This limestone is exceptionally high in calcium oxide content.



Loading methods approved by the carrier insure contents reaching customers in perfect condition.



Clarence Center Plant Located in the Heart of Western New York's Rich Gypsum Deposit.

NATIONAL GYPSUM COMPANY

THE Gold Bond HANDBOOK

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